

2 Technology Research and Deployment Plan

ITP includes 14 program elements with appropriated funding in FY08. Each of these program elements will be described in more detail below. For each program element, the MYPP presents an overview, followed by a current snapshot of the milestone chart. Accompanying the chart is a table that enumerates barriers, pathways and metrics for each technology focus area. Additionally, where applicable, the energy footprint, roadmap summary, and bandwidth study are included.

Standardized wording for certain focus areas appears on most milestone charts. Those areas are:

- Cross-EERE Activities
- BP Integration / Technology Delivery
- Studies & Analysis

Stage Gate Process

ITP has drafted a document defining its stage gate process, entitled *Stage Gate Innovation Management Guidelines*. The ITP portfolio management guidelines are based on Stage Gate™ principles (a registered trademark of R.G. Cooper & Associates), a methodology which has been successfully applied throughout industry and government (Cooper 2002, Cooper 1998, GRI 1995). Stage Gate is a phased project development approach that produces fact-based funding decisions based on a set of defined evaluation criteria. The ITP Stage Gate process builds upon the guidelines for the methodology contained in the *EERE RDD&D Decision Process – Standard Model*.

Specifically, Stage Gate will be used by ITP to:

- Provide consistent program and project management guidelines
- Characterize projects in terms of scope, quality, performance, and program integration
- Evaluate and monitor project progress against milestones and metrics
- Assess viability of technology commercialization
- Guide decisions on project funding (e.g., go forward, stop, hold, return)

A key tenant of the Stage Gate model is that funding commitments for projects are initially low, and will increase as work progresses and confidence in a successful outcome rises. Early focus is placed on exploring the most uncertain and risky technical elements, to minimize spending in the long-term. Conducting a thorough background study of the potential for the technology and its expected economics in the initial stages provides important information for making judgments about the project along the way. The expectation is that projects with serious technical or other issues will be identified early-on, enabling greater investment in the projects with the greatest probability for success.

Commercialization Track Stages

Stage 1 – Preliminary Investigation and Analysis: Scoping studies to identify research topics; technical and market assessments; idea generation.

Stage 2 – Concept Definition: early stage research to explore and define technical concept or to answer a specific technical question; laboratory scale research.

Stage 3 – Concept Development: development and testing of prototype technology or process; development of models and informational databases; predictive modeling or simulation of process or equipment performance; evaluation of scalability and end-user acceptability; demonstration of concept feasibility at the prototype or bench scale.

Stage 4 – Technology Development and Information Validation: pilot scale development of technology or process; technology field test and validation of economic potential; verification and documentation of information.

Stage 5 – Information Dissemination and Commercialization: all activities necessary for information delivery and commercial launch (production scale technology manufacture and installation; development of market infrastructure; demonstrated commercial operation).

For projects that are expected to produce a commercial process or technology product, stages and gates are designed to facilitate the development of new technology and enable industrial partners to take it forward to commercial launch. Projects that focus on information generation, which may range from fundamental scientific research to the dissemination of information about technology developments, similarly use the stage-gate process to ensure outcomes are valuable to end-users.

Stage and gate criteria have been developed that are uniquely suited to the type of projects funded by ITP. More details, including stage descriptions and gate review criteria, can be found in the stage gate document.

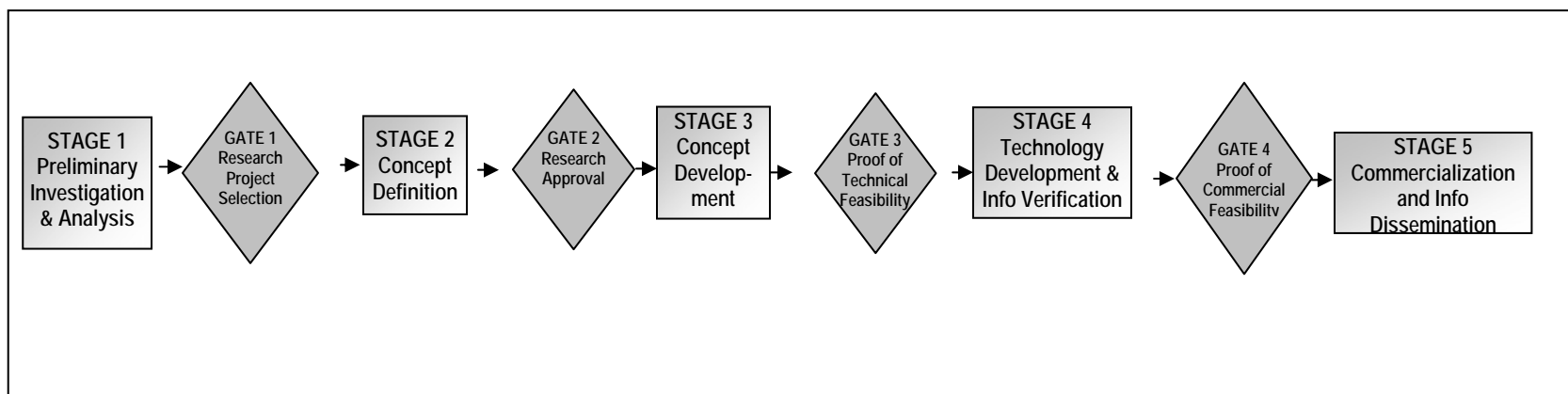


Figure 2-a. ITP Stage Gate Project Decision-Making Process

Corporate Milestones

In the summer of 2002, ITP initiated a formalized process to track and maintain program milestones. These program milestones have been identified at junctures along the critical path toward the program objectives and goals. They mark key decision points for determining, as early as practical, whether the program is on track to meet its objectives. The purpose is to facilitate timely adjustments to the program strategies, if necessary. The milestone charts that have resulted from this process are reviewed quarterly, with updates published. In conjunction with the charts, an overview of the key technology barriers and proposed pathways are included, along with metrics that focus on the key measurements of ITP success: energy savings; cost savings; environmental impact; and commercialization potential.

In this Multi-Year Program Plan, each of the planning units, or sub-programs, has identified key milestones within major focus areas. These milestones are represented in the individual planning unit charts that follow in section 3 of this document. These key milestones are selected because progress against them is indicative of the health of the technical focus area they represent. Progress on the most important of these milestones can be indicative of the health of the whole planning unit and are, therefore, of interest at the corporate level.

What follows is a chart of the nominated milestones, by year, as submitted by each planning unit.

PROGRAM MILESTONES 2008-2012

Program Area	Milestone/Deliverable	Completion Date
Industry-Specific Applications	Establish 'best practice' in melting with 10% energy savings in producing die castings	Q4-FY08
	Complete microchannel reactor system optimization, integration and evaluation for catalytic hydrogenation with 90% reduction in energy	Q4-FY08
	Create completely safe, energy-efficient reheat system that significantly minimizes or eliminates scale formation during steel reheating	Q1-FY09
	Complete scale-up and field tests of highly selective oxidation catalysts to achieve conversion efficiency >80% and selectivities >90%	Q3-FY09
	Complete mill trial of directed green liquor utilization (D-GLU) pulping process with 20% energy reduction	Q2-FY10
	Demonstrate energy- efficient production of high quality iron that is equivalent in quality to blast furnace pig iron and can be used directly by electric steelmaking processes	Q2-FY10
	Begin efforts to scale up the ITM capacity to 150,000 lb/hr with 70% energy savings potential	Q1-FY11
	Develop innovative casting process with 20% improvement in productivity and energy efficiency	Q4-FY12
Crosscutting Technologies	Complete installation of gas composition microanalyzer at operating field sites resulting in energy savings of 1-5% depending on the application	Q3-FY08
	Commission 4.6 MW CHP system at food processing plant to recover waste heat for process use, increasing overall efficiency	Q4-FY08
	Extend maximum use temperature of aerogel insulation to 1200 F and reduce production cost by about 10%	Q4-FY08
	Demonstrate Transport Membrane Condenser (TMC) in a retrofitted conventional boiler to recover waste heat and improve efficiency towards 94% goal	Q4-FY09
	Conclude first field trial of >94% efficiency watertube boilers capable of 1,500 F and 1,500 psi steam	Q3-FY10
	Conduct demonstration of solid-state steel welding in plant operations with >15% energy savings	Q4-FY10
	Complete design of modified burners to run on gas with Btu content of less than 500 Btu/scf	Q4-FY10
	Complete development of two non-destructive quality control methods to enable nanomaterial manufacturing	Q4-FY11
	Demonstrate a non-thermal dewatering technology that reduces energy requirements by at least 20%	Q4-FY11
	Manufacture prototype transient processing systems and successfully demonstrate commercial viability in plant trials with energy savings in excess of 20%	Q1-FY12
Technology Delivery	Conduct 300 assessments by the end of the calendar year	Q1-FY08, 09, 10, 11
	Train 200 engineering students in energy efficiency through IACs	Q4-FY08, 09, 10, 11
	Award 25% of plants receiving IAC assessments Energy Saver Plant or Energy Champion status for previous calendar year	Q2-FY08, 09, 10, 11
	Train/mentor 26 local MEPs in energy efficiency tools, resources and practices	Q4-FY08, 09, 10, 11
	Get companies to sign Save Energy Now Leaders pledge - 60 by FY09	Q4-FY08, 09, 10, 11

Program Area	Milestone/Deliverable	Completion Date
	- 200 by FY10 - 240 by FY11	
	Complete 4 online issues of <i>Energy Matters</i> ; complete 12 monthly issues of <i>E-Bulletin</i>	Q4-FY08, 09, 10, 11
	Present annual awards; hold SEN Champion Awards Event and Leader Awards Event	Q4-FY08, 09, 10, 11
	Award 16 or more states state-level Save Energy Now awards	FY09, 10

2.1.1 Aluminum

Background

The United States aluminum industry is the world's second largest, processing 9.6 million metric tons of metal and producing about \$40 billion in products and exports in 2003. U.S. per capita consumption was 29.5 kilograms. The industry operates more than 400 plants in 41 states and employs more than 145,000 people. Aluminum impacts every community and person in the country, through either its use and recycling or the economic benefits of manufacturing facilities.

Energy reduction in the U.S. aluminum industry is the result of technical progress and the growth of recycling. These two factors have contributed 22% and 39% respectively to the total 61% energy reduction achieved over the past 40 years. However, this strategic metal whose light-weight characteristics are essential in transportation and aerospace among other applications, remains one of the most energy-intensive materials to produce. Even with large reductions in energy intensity, the industry consumes nearly three times the theoretical minimum energy required. In addition, there are concerns about the continuous decrease in domestic primary aluminum production capacity due to increased energy and alumina costs. Domestic smelters only operated at about 63% of rated or engineered capacity in 2004.

Major energy-consuming processes for aluminum are smelting and thermal processing, which includes melting, molten metal holding, purifying, alloying, and product heat treating. Smelting is the most energy-intensive of these processes requiring 46% of the total energy consumed in the U.S. manufacturing of aluminum. This area represents the largest single energy savings opportunity. However, the Aluminum portfolio's limited resources preclude major work in primary smelting since the scale and scope of this work requires very significant long-term investment. In addition, smelting is used only by the primary aluminum industry, a subsector that has shrunk dramatically in this country and is predicted to continue moving offshore to countries with low electricity costs. Current R&D efforts are focused on other (non-primary) areas where resources spent will yield energy savings in the near-term. DOE supports two functional areas, advanced melting and innovative forming.

The second largest energy consuming operation is thermal processing and DOE is supporting R&D in this area. It accounts for 27% of the total energy consumed in manufacturing of aluminum and over 52 trillion Btu/year of the energy consumed in the United States. *ITP's analysis shows that 40-50% energy savings are possible in melting, hot rolling, and other thermal processing operations.* The results of the R&D efforts in melting technologies are applicable to many U.S. industries that utilize furnaces, ovens, kilns, refractory and high-temperature technologies. The advanced melting work could lead potentially to a paradigm shift in the industry by eliminating melting and holding furnaces at the casting cell and moving to centralized, off-site facilities. This work is being performed by Apogee Technologies and other partners. The second area supported by DOE is innovative forming and seeks to save energy by minimizing the planned or incidental scrap in the hot rolling of aluminum ingot. The scrap has to be re-melted which wastes an enormous amount of energy. This work is being conducted at the University of Illinois - Urbana Champaign and others.

Strategy

The Aluminum portfolio strategy is to continue improvements in melting – heat loss reduction, heat recovery and reduction of oxidation losses – where improved energy efficiency and product quality can be realized. Forming technologies are relatively small energy consumers compared to melting but will be supported in cases where improvements in yield avoid remelting or where energy savings can be obtained by expanding proven technologies (i.e., continuous casting of sheet products).

Funding activities will be distributed among university, national laboratory and industry-based researchers. Their activities will address the high priority melting and forming research needs described in the Vision and Roadmap documents: Advanced Melting Technologies, and Innovative Forming Technologies. Melting activities are aimed at improving the thermal efficiency of the melting processes and technologies and with geographically optimized central melting operations. Forming activities are aimed at reducing scrap and losses, especially at the edges of rolled aluminum products. Since these processes and technologies can be readily integrated into current production practices, they can have a significant impact on energy savings in the aluminum industry.

End States

The end state is defined as the time when the federal government can step out of the process of technology research and development, and further development is picked up and continued by industry. This is, in many cases, difficult to forecast but should be considered in formulation of strategy and funding plans. For the focus areas of the Aluminum



portfolio, the end states, at this time are considered to be:

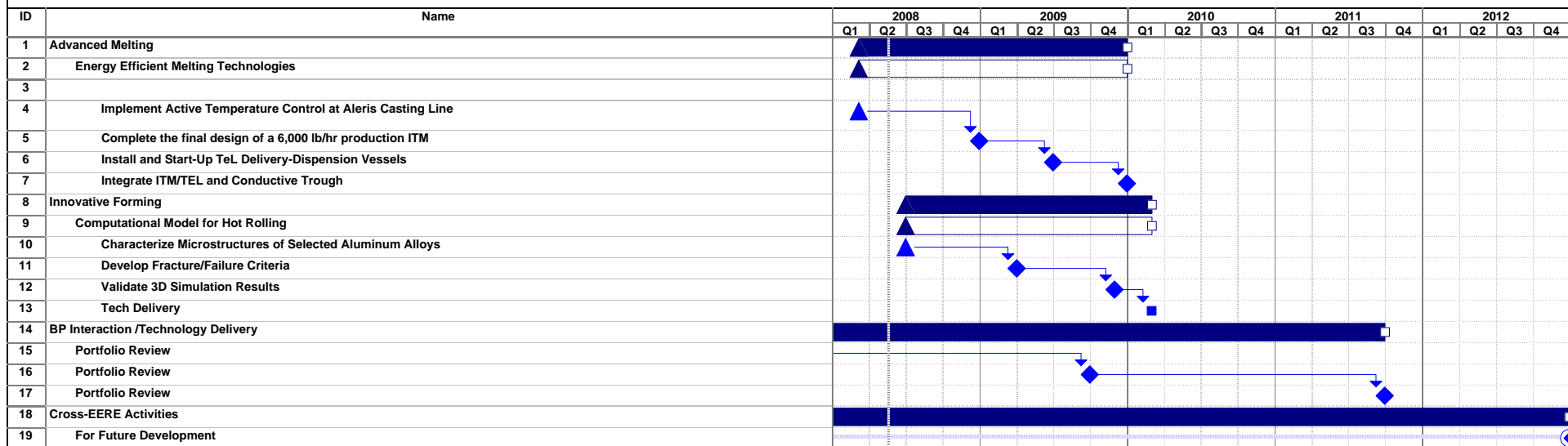
Advanced Melting. The end state will be successful demonstration that theoretical practical minimum energy use can be obtained using technologies developed with federal funding. This will, of necessity, require integration with product manufacturing, reduction of lost heat, reduction of oxidative melt losses and recovery of energy from the melting process.

Innovative Forming. The end state will be reached when virtually no additional benefit can be derived from further increasing yield, reducing scrap rates, avoiding remelt and when the limitations on continuous casting alloy have been reduced as much as possible.

Last updated: 5/5/2008



Aluminum



R&D Strategy Focus Area	Barriers	Pathways	Metrics
Advanced Melting (1) <u>Objective</u> Develop melting systems that reduce metal oxidation and energy consumption	<ul style="list-style-type: none"> The aggressive nature of molten aluminum and aluminum purifying processes (e.g., gas fluxing with Cl₂) limits heat conservation or recovery by modifications to furnace refractory, recuperator and other system materials (2) Aluminum oxidizes readily, resulting in metal lost to oxidation (2-8%) during the melting and holding operations (2) 	Efficient Melting Technologies pathways will provide the aluminum industry with advanced melting technologies that could potentially use immersed electric heaters to melt metal by heat conduction and convection. In FY2008, the conductive trough will be installed and started up and the final design for a 7,000 lb/hr ITM will be completed. The Apogee Technology project plans to construct and commission the IsoThermal Melter (ITM) and routinely operate it to measure performance. It also plans to build, test and validate the turboelectric ladle (TeL) design and develop, install and successfully operate the TeL fill docking station at IMCO. In FY2009, the TeL will be installed and the ITM, TeL and CT will be fully integrated. In FY2010, the ITM system will supply fully processed high quality molten aluminum directly to the casting lines, using an off-site melter with high energy efficiency, to support one foam casting line at General Motors with a nominal throughput of 6,000 lb/hr. In FY2011, the project team will begin efforts in scaling up the ITM capacity to 150,000 lb/hr with 50% energy savings potential.	Demonstrate melting operation at less than 1% melt loss (compared to current 2-3% loss) and 70% reduction in energy intensity (from current thermal efficiency level of less than 30%). <i>Total potential savings = 20 trillion Btu/year</i>
Innovative Forming (2) <u>Objective</u> Reduce scrap and energy consumption by developing predictive models that relate alloy microstructure and properties to specific forming processes	<ul style="list-style-type: none"> Lack of models capable of relating structural properties to manufacturing process and the materials employed (1) Lack of accurate materials data, including elemental data by alloy type (1) Lack of accurate process design data and integrated process models (1) Lack of models that allow reverse engineering (1) 	The Computer Modeling for Hot Rolling Scrap Reduction pathway will improve the total rolling-plant recovery of aluminum process from ingot to final products. This will be done through: 1) linking microstructure to macroscopic properties of aluminum and rolling process parameters; 2) predicting history of deformation and damage evolution in hot rolling; 3) optimizing processing parameters to reduce scrap in hot rolling and validate the integrated models; 4) demonstrating the predictive ability of the integrated model as a process optimization tool for hot rolling; and 5) using the integrated models to significantly reduce both planned and incidental scraps in hot rolling.] In FY2008, the microstructures of selected aluminum alloys will be characterized and the criteria for fracture/failure will be developed. In FY2009, the 3D simulation results will be validated.	Significantly reduce both planned and unplanned scrap in hot rolling, and improve the rolling process recovery by at least 10%. <i>Total potential savings = 1 trillion Btu/year</i>

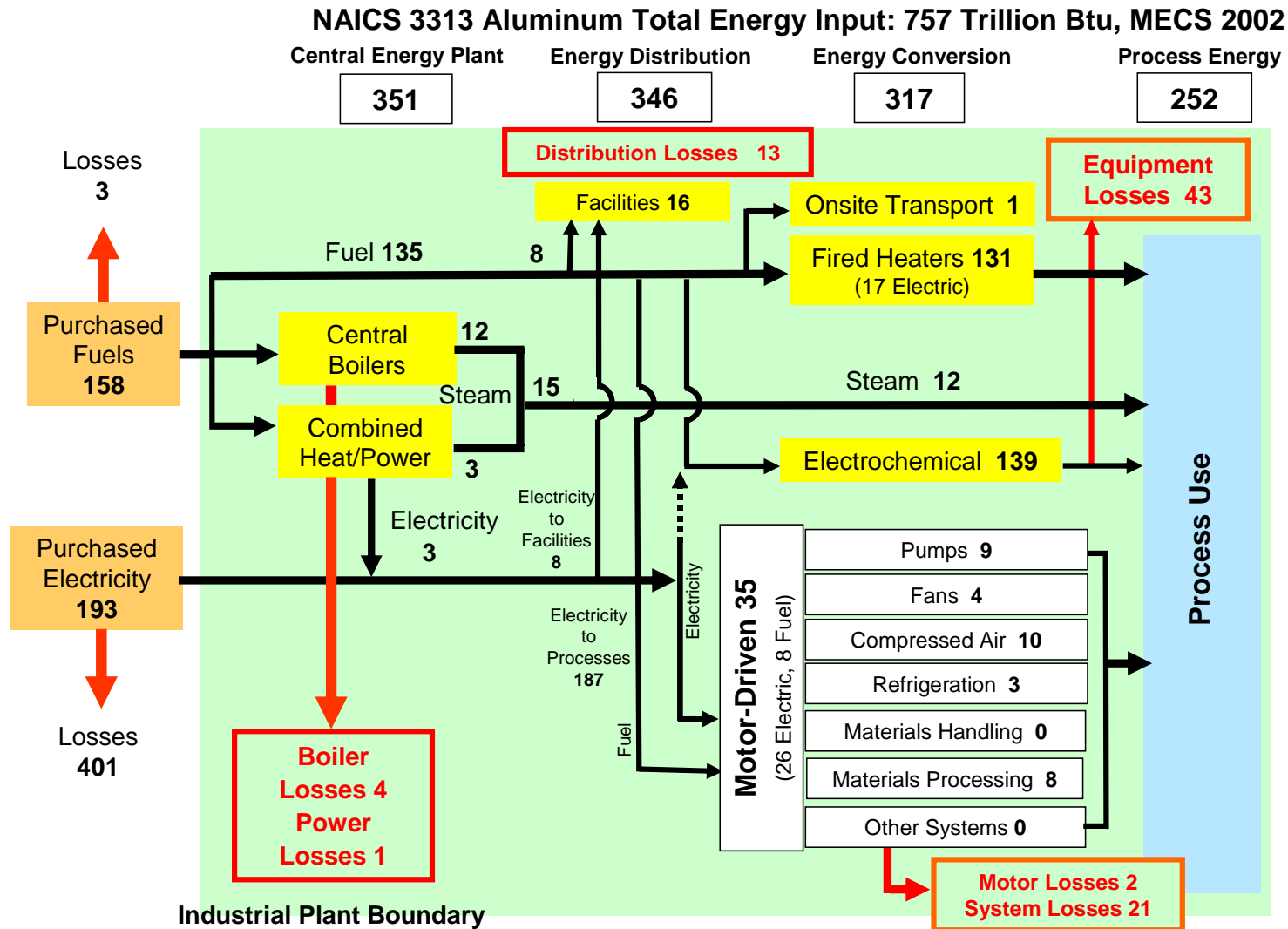


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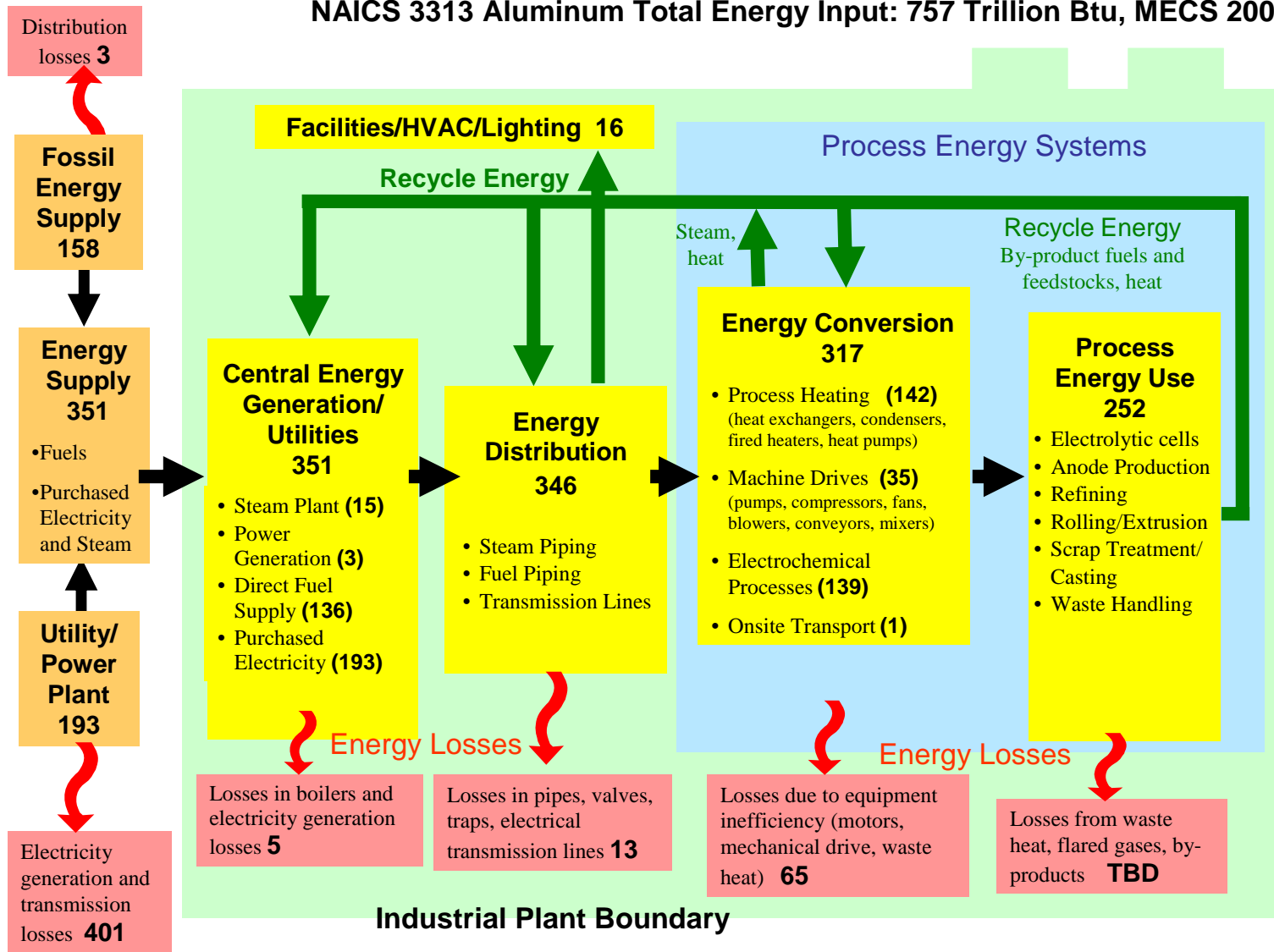
- (1) U.S. Department of Energy, Energy Efficiency and Renewable Energy, Industrial Technologies Program, Aluminum Industry of the Future, *Aluminum Industry Technology Roadmap*, Washington D.C., February 2003.
- (2) U.S. Department of Energy, Energy Efficiency and Renewable Energy, Industrial Technologies Program, Aluminum Industry of the Future, *U.S. Energy Requirements for Aluminum Production; Historical Perspective, Theoretical Limits and New Opportunities*, Washington D.C., February 2003.



2.1.1.1 Aluminum Footprint

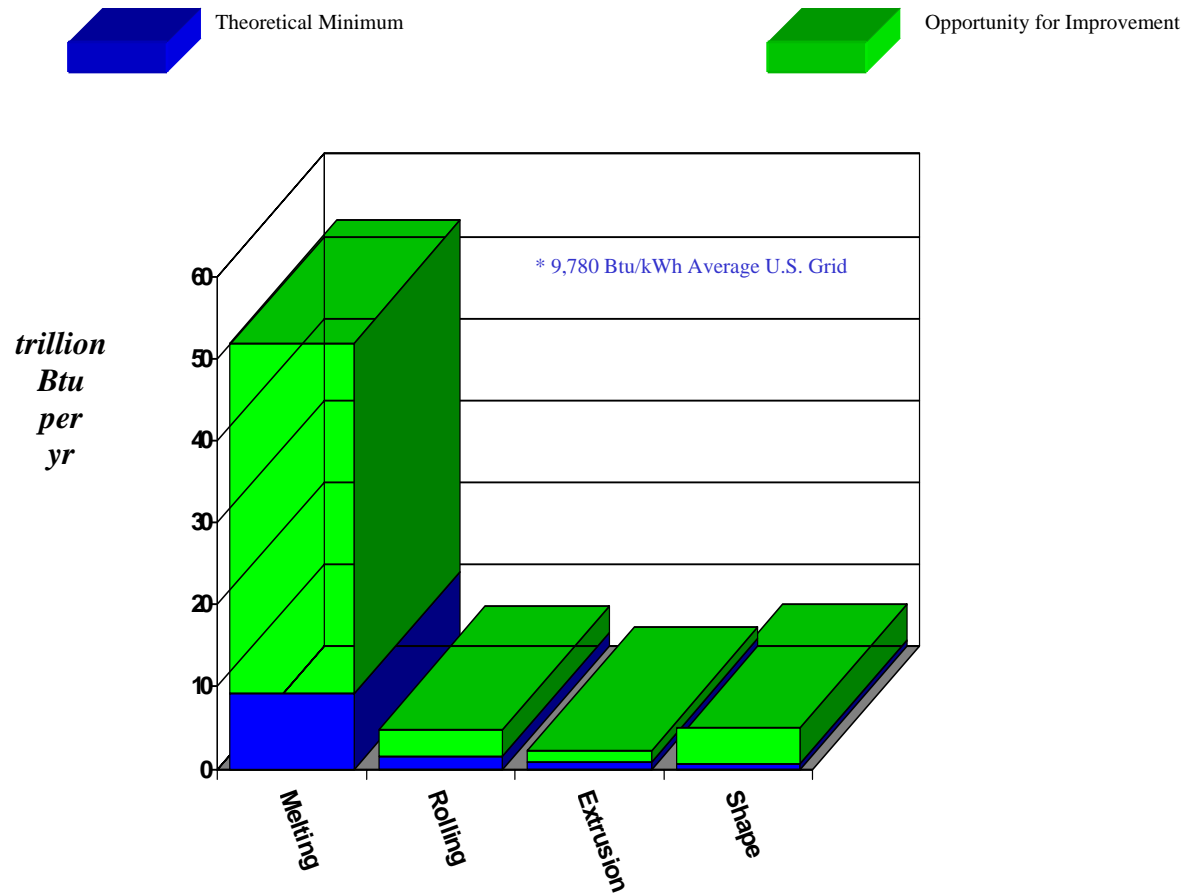


NAICS 3313 Aluminum Total Energy Input: 757 Trillion Btu, MECS 2002



2.1.1.2 Aluminum Bandwidth Analysis

U.S. Annual Tacit Energy Consumption by Process, 2003



2.1.2 Chemicals

Background

The Chemical Industry is a keystone of the U.S. economy, converting raw materials (oil, natural gas, air water, metals, and minerals) into more than 70,000 different products. Few goods are manufactured without some input from the chemical industry. Chemicals are used to make a wide variety of consumer goods, as well as thousands of products that are essential input to agriculture, manufacturing, construction, and service industries. The chemical industry itself consumes 26 percent of its output. Major industrial customers include rubber and plastic products, textiles, apparel, petroleum refining, pulp and paper, and primary metals.

Chemicals are nearly a \$1.5 trillion global enterprise, and the U.S. chemical industry is the world's largest producer. There are 170 chemical companies with more than 2,800 facilities abroad and 1,700 foreign subsidiaries or affiliates operating in the United States. According to the Energy Information Administration, the chemical industry records large trade surpluses and employs more than a million people in the United States alone. The chemical industry is also the second largest consumer of energy in manufacturing and spends over \$5 billion annually on pollution abatement.

The U.S. Department of Energy's Industrial Technologies Program has formed a partnership with the U.S. chemical industry to accelerate the development of technologies and processes that will improve the industry's energy efficiency and environmental performance. ITP's analysis of the top 40 chemicals (by volume) shows that energy savings of 67% are possible through the development and use of new technologies and processes.

Strategy Statement

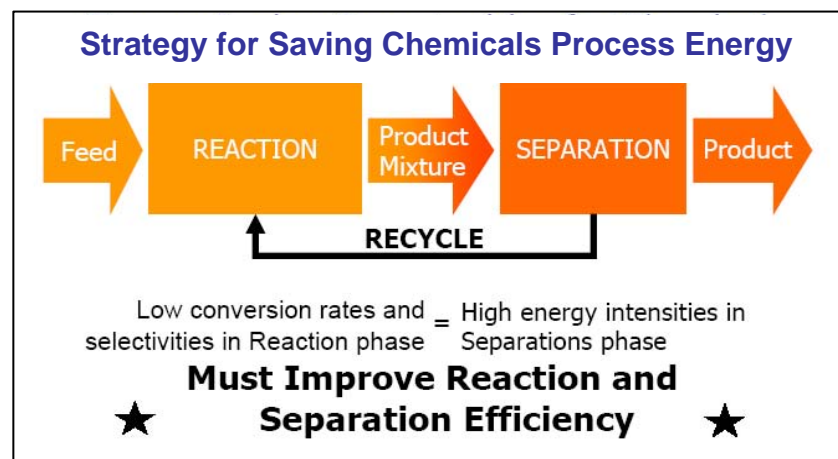
The Chemicals Subprogram overall strategy is illustrated in the figure to the right.

Most chemical processes begin with a reaction and are followed by a separation of the product mixture into desired product, unreacted feedstock, and unwanted by-products. The unreacted feedstock and unwanted by-products are recycled back to the reactor. Since most industrial reactions have typically low conversions and selectivities, the separation train is usually both energy and capital intensive. Similarly, the recycle loop is usually large, resulting in large electrical energy required to pump the liquids or compress the gases in order to move the fluids around. The equipment sizes in the recycle loop are also large, again translating into large capital.

Therefore the chemicals strategy is to focus on improving the reaction conversion and selectivities, while also looking at ways to improve the efficiency of separation processes.

The following are strategies for each focus area in the Chemicals subprogram:

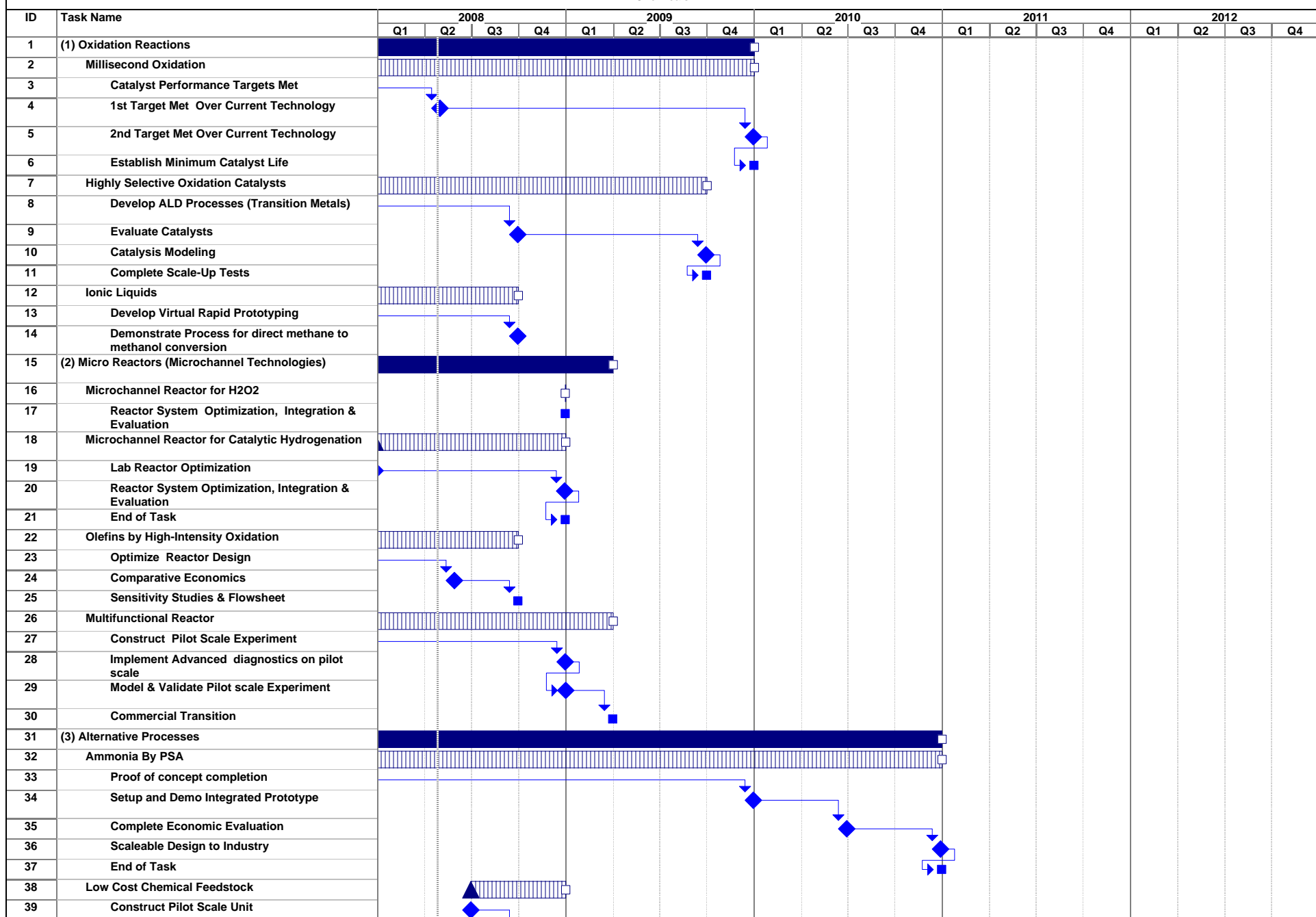
1. **Strategy for Oxidation Reactions Focus Area:** This focus area represents about 80% of industrial reactions; hence any breakthrough in this area will have huge impact on the majority of industrial reactions. Emphasis will be on the development of high conversion and selectivity oxidation catalysts, that operate at moderate temperatures and pressures; improvement of better catalyst design and characterization methods; and establishment of better procedures for the operation of laboratory, pilot and plant reactors.
2. **Strategy for Micro Reactors Focus Area:** Development of micro reactors enables the practice of process intensification. Process intensification is new buzzword for processes which minimize feedstock and energy usages, leading to higher product yield, smaller size equipment and inherently safer environment because quantity of materials is below explosive limits. A microchannel reactor is a new concept that has the potential to impact the entire industrial reactions if successful. Therefore research in this area should focus on micro-channel reactors and process intensification to obtain high reactor yield with less feedstock, and better heat transfer and material mixing characteristics.



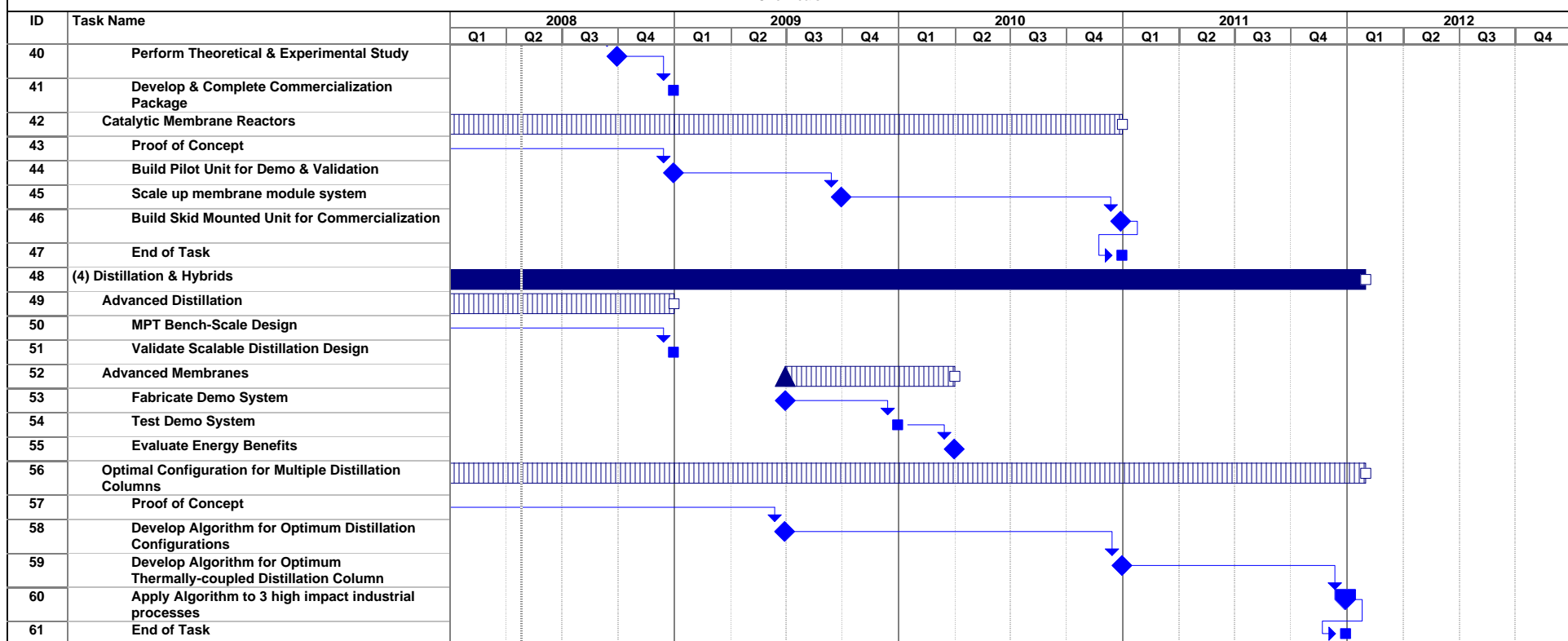
3. **Strategy for Alternative Processes Focus Area:** Our bandwidth studies revealed some old chemical products' manufacturing technologies which are very energy intensive. The strategy here is to explore new process chemistry and chemical process synthesis to replace these archaic chemical product processes like ethylene and ammonia that are on top of the list for most 50 energy intensive processes.
4. **Strategy for Distillation & Hybrids Focus Area:** The Separations area focuses on hybrid distillation technologies like distillation-adsorption, distillation-membranes, distillation-crystallization, extractive distillation, azeotropic distillation, and reactive distillation. Distillation equipment accounts for over 90% of the separations equipment deployed in the chemical and petroleum industry and yet it is very energy intensive. Therefore any slight improvement of its efficiency should translate to significant energy savings. Recent thermodynamic analysis shows that theoretically 40% energy savings is possible with improvements in the current designs. Yet design improvements in existing equipment to date have yielded only marginal efficiency, hence hybridizing it with other separation technologies may give much better efficiencies and reduce the energy usage in distillations, since the feed into the columns must have already been pre-concentrated before entering the distillation columns. A second area to focus on is reactive separations. Taking one component out while the reaction is proceeding has been one way of driving equilibrium reactions to completion and is therefore an important area to focus on. Any major breakthrough in membranes for separation of hydrocarbons will have huge impact in the whole manufacturing industry because of prolific applications. Membranes could replace distillations if they are developed to be technically efficient and economically attractive. One major problem with inorganic membranes in separating hydrocarbons is lack of understanding of the phenomenon at the interface as well as the prohibitive cost of commercial membrane modules. The R&D effort in this area will focus on solving these two main problems first.

Last updated: 5/5/2008

Chemicals



Chemicals



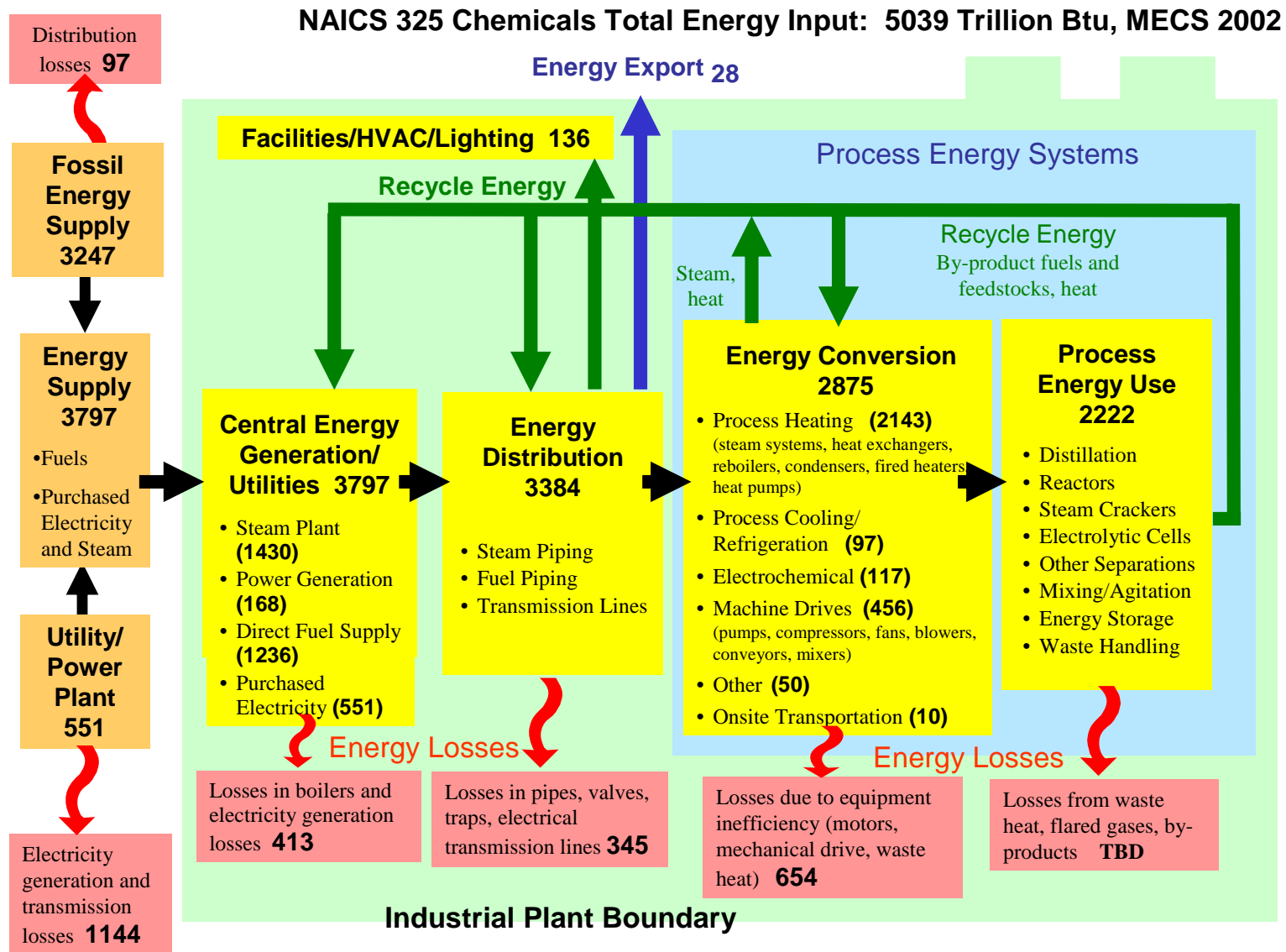
R&D Strategy Focus Area	Barriers	Pathways	Metrics
Oxidation Reactions <u>Objective</u> Develop technologies that will increase conversions > 60% and selectivities > 70% for oxidation reactions.	1. Catalysts operate at high temperatures (> 250 deg. C) and pressure (> 1 atm) 2. Poor catalyst designs 3. Lack of optimal reaction media	1. Develop catalysts that operate at moderate temperatures (<100 deg. C) and pressures (1 atm.), for homogeneous or heterogeneous catalyzed processes. Focus on selective oxidation, alkane activation, selective synthesis, and alkylation. Meet 1 st catalyst performance target by Q2 of FY08. Meet 2 nd catalyst performance target by Q4 of FY09. Establish minimum catalyst life by Q4 of FY09. <i>[Millisecond Oxidation – Rohm & Haas]</i> 2. Develop new catalyst design through combined experimental, mechanistic understanding, and improved computational modeling of catalytic processes. Complete catalyst modeling by Q3 of FY08. Complete catalyst evaluation by Q3 of FY09. Complete scale up and field tests by Q3 of FY09. <i>[Highly Selective Oxidation Catalysts – ANL]</i> 3. Develop and evaluate ionic liquids as alternative reaction media Completed virtual rapid prototyping in FY07. Demonstrate optimized solvent by Q3 of FY08. Complete demonstration of process for direct methane to methanol conversion also by Q3 of FY08. <i>[Ionic Liquids - California Institute of Technology]</i> <i>Combination of Ionic Liquids and Microchannel reactors to reduce energy consumption for both reactions and separation simultaneously will be addressed in FY08 solicitation]</i>	1. Demonstrate catalysts with 60% conversions and 70% selectivities operating at 1 atm pressure and temperatures < 100 C. <i>Total potential savings = 20 trillion Btu/year</i> 2. Demonstrate catalysts with conversions > 80% and selectivities > 90%. <i>Total potential savings = 25 trillion Btu/year</i> 3. Demonstrate reaction in ionic liquids with conversion >60% and selectivity > 70%, and non-thermal separation method that will take advantage of the presence of ions (membranes, adsorption, and ion-exchange) <i>Total potential savings = 5 trillion Btu/year</i>

<p>Micro-Reactors</p> <p><u>Objective</u></p> <p>Develop micro reactor technologies that will reduce reaction feedstock by 20%, increase reaction yield by 20% and increase reactor safety by eliminating potential for explosion.</p>	<ol style="list-style-type: none"> 1. Conventional reactors cannot handle mixing of reactants and uniform heat transfer very well and sometimes have "hot spots" due to poor mixing 2. Catalyst's inefficiency leads to high use of feedstock 3. High use of feedstock poses risk of explosion during oxidations and hydrogenations 	<ol style="list-style-type: none"> 1. Develop novel and/or non-standard reactors coupled with Process Intensification like micro-channel reactors where amount of reactants stay below explosive limits and reactor design ensures high yield with less feedstock and better heat transfer and material mixing. <ol style="list-style-type: none"> a. Complete Reactor System Optimization, Integration and Evaluation by Q4 of FY08. [<i>Micrchannel Reactor for H₂O₂ Production. – Stevens & FMC</i>] b. Completed laboratory reactor optimization by Q4 of FY07. Complete Reactor System Optimization, Integration and Evaluation by Q4 of FY08. [<i>Microchannel Reactor for Catalytic Hydrogenation – Stevens Inst.</i>] c. Completed Reactor Design Optimization by Q4 of FY07. Complete comparative economics by Q2 of FY08. Complete sensitivity studies and flowsheet development by Q3 of FY08. [<i>Olefins by high intensity Oxidation – Velocys</i>] d. Completed pilot scale unit construction/experimentation in Q4 of FY07. Implement advanced diagnostics on pilot scale by Q4 of FY08. Complete modeling and validation of pilot scale experiment by Q4 of FY08. Complete commercial transition by Q1 of FY09. [<i>Multifunctional Reactor – SNL</i>] 	<ol style="list-style-type: none"> a. Demonstrate microchannel reactor pilot unit producing 1-5 wt% H₂O₂ <i>Total potential savings = 24 trillion Btu/year</i> b. Demonstrate a continuous microchannel hydrogenation reactor pilot unit with ~ 100% conversion and 90% reduction in energy. <i>Total potential savings = 64 trillion Btu/year</i> c. Demonstrate micro reactor technology with savings in feedstock about 20% than conventional. <i>Total potential savings = 22 trillion Btu/year</i> d. Demonstrate a microchannel reactor that can be used for different reactions with little adaptation. <i>Total potential savings = 22 trillion Btu/year</i>
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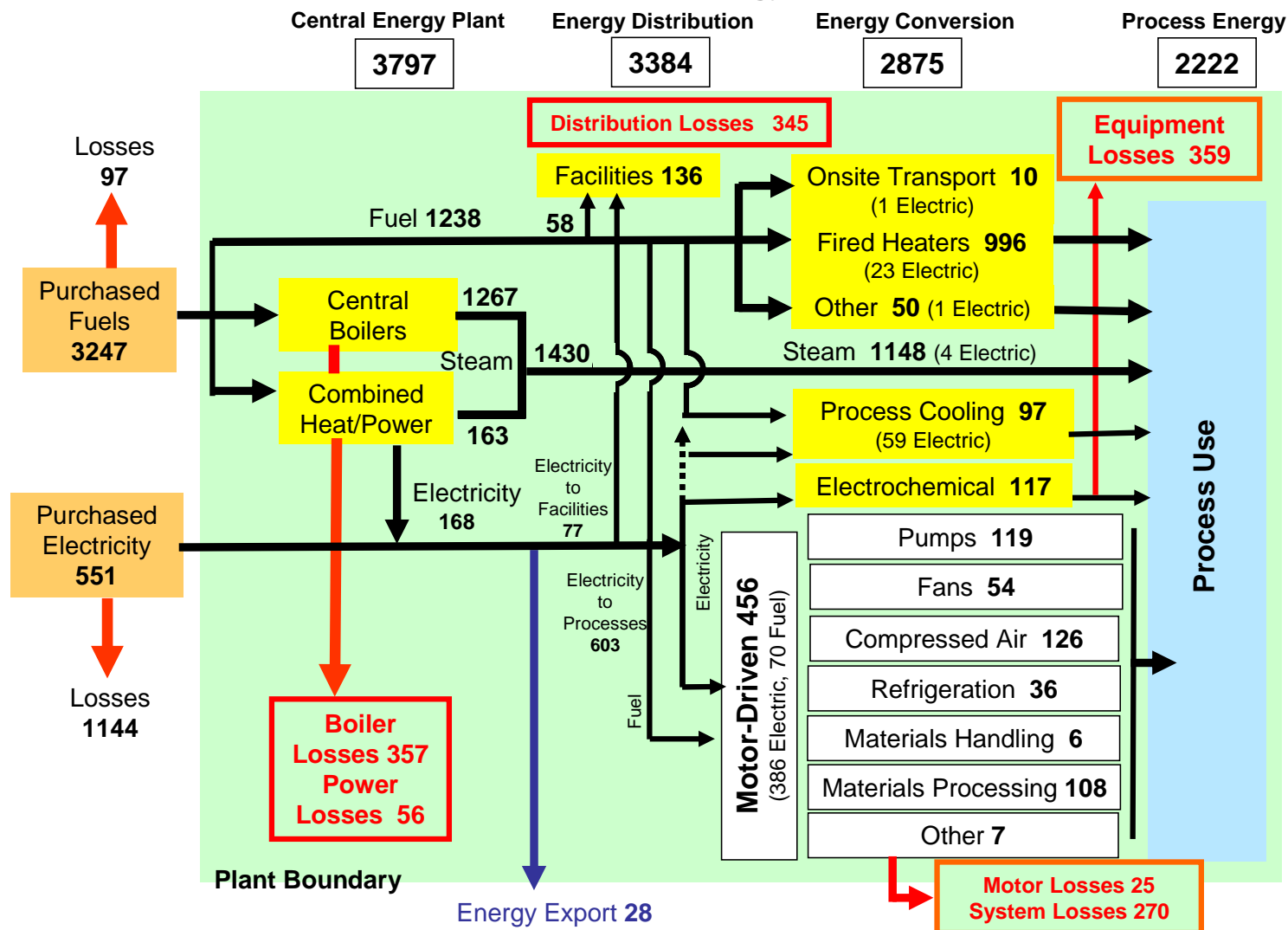
<p>Alternative Processes</p> <p><u>Objective</u></p> <p>Develop new technologies with new chemistry and process synthesis to replace very old and high energy intensive processes.</p>	<p>1. Many old industrial processes plagued by reactions with high temperatures (> 300 deg. C) and pressure (> 2 atm.).</p> <p>2. Current processes are equilibrium limiting</p>	<p>1. Develop entirely new processes using process synthesis techniques based on complete new chemistry and new routes for manufacture of these energy intensive commodity chemicals – ethylene, ammonia, etc.</p> <p>a. Proof of concept completed in Q4 of FY07. Complete set up and demonstrate integrated prototype by Q4 of FY09. Complete economic evaluation by Q2 of FY10. Complete Scalable design and industrial testing by Q4 of FY10. <i>[Ammonia production by PSA—Smart Koncept]</i></p> <p>b. Pilot scale unit construction started in FY07 will be completed by Q2 of FY08. Performance of experimental study will be completed by Q3 of FY08. Development of completes commercialization packages will be completed by Q4 of FY08. <i>[Low Cost Chemical Feedstock (Ethylene) – ANL]</i></p> <p>2. Develop membrane reactors, reactive separation technologies to shift equilibrium to favorable directions.</p> <p>Proof of concept completed in Q4 of FY07. Complete building pilot unit for demonstration and validation by Q4 of FY08. Complete scaling up membrane module system by Q3 of FY09. Complete building a skid mounted unit for commercialization purposes in Q4 of FY10. <i>[Catalytic Membrane Reactors - Compact Membrane Systems]</i></p>	<p>1. Demonstrate novel process with new chemistry and chemical synthesis route for one of the top 5 most energy intensive processes (Ethylene, Ammonia, Ethylene Oxide, Terephthalic Acid (TPA) and with a shut down economics such that pay back time <5 years and ROI up to 50%.</p> <p><i>Total potential savings = 12 trillion Btu/year</i></p> <p>2. Demonstrate a membrane reactor technology where more than 90% of water produced in the reaction is removed simultaneously through the membrane walls, thus driving the reaction conversion to nearly 100% and selectivity to about 90%.</p> <p><i>Total potential savings = 4 trillion Btu/year</i></p>
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<p>Distillation and Hybrids</p> <p><u>Objective</u></p> <p>Develop technologies to increase the efficiency of distillation columns by 40% (100 to 2,000 Btu/lb, depending on the product being separated) in order to impact the nearly 900 trillion Btu used in the U.S. each year for distillation.</p>	<p>1. Conventional distillation technology has many physical fundamentals that are not well understood, including transport phenomena such as fluid flow, poor heat and mass transfer characteristics, poor mixing associated with multi-phase flow processes occurring within trayed or packed distillation columns, et cetera.</p> <p>2. Conventional Distillation columns consumes too much energy when not hybridized with other separation unit operations.</p> <p>3. Currently, no method exists for determining the optimal arrangement of multiple distillation columns for multi-component distillation columns.</p> <p>Distillation – lack of physical fundamentals including accurate real stage efficiency calculation, mixing characterization, understanding of distillation phenomena, vapor liquid imaging techniques, ability to measure and understand multi-phase flow; and inability to see inside distillation columns, lack of effective sensors, modeling capabilities to predict and optimize equipment performance.</p>	<p>1. Develop and evaluate the efficiency alternative non-conventional distillation technology like the application of micro-channel technology to a horizontal distillation column and compare results with conventional distillation technology and decide on the next steps.</p> <p>MPT Bench Scale Design was completed in Q4 of 2007. Complete Validation of Scalable Distillation Design by Q4 of FY08. <i>[Advanced Distillation – Velocys]</i></p> <p>2. Develop other separation technologies (membranes, adsorption, etc) that can be used as hybrids with conventional technologies that will improve column efficiencies upwards to 40%.</p> <p>Complete the fabrication of membrane demonstration system by Q2 of FY09. Complete testing the demo system by Q4 of FY09. Complete the evaluation of energy benefits by Q1 of FY10. <i>[Advanced Membranes – Air Products]</i></p> <p>3. Develop an algorithm that will lead to software for designing the optimal columns configuration for multi column, multi component distillation columns.</p> <p>Completed proof of concept in Q4 of FY07. Complete development of algorithm for optimum distillation columns configurations by Q2 of FY09. Complete development of algorithm for thermally coupled optimum distillation columns configurations by Q4 of FY10. Complete applying algorithm to 3 high impact industrial processes by Q4 of FY11. <i>[Optimal Configuration for Multi Component Multi Distillation Columns – Purdue University]</i></p>	<p>1. Demonstrate a micro-channel, horizontal distillation technology and obtain engineering data from the scaled up unit for analysis to determine if this configuration has any advantages over conventional distillation columns.</p> <p><i>Total potential savings = 14 trillion Btu/year</i></p> <p>2. Demonstrate a good membrane system that will serve as a pre-concentrator to a distillation column such that the efficiency of the distillation column is close to 40%.</p> <p><i>Total potential savings = 19 trillion Btu/year</i></p> <p>3. Demonstrate an algorithm and computer software for evaluating different arrangements for multiple distillation columns for separating multiple components such that the optimal arrangement will give overall efficiency of the system close to 40%.</p> <p><i>Total potential savings = 14 trillion Btu/year</i></p>
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Chemicals Footprint



NAICS 325 Chemicals Total Energy Input: 5039 Trillion Btu, MECS 2002



Chemical Industry Vision 2020 Roadmaps

Catalysis

- **Catalysis Applications:** Lower energy requirements via higher selectivity, more moderate temperature or pressure, and reduced number of unit operations for the homogeneous or heterogeneous catalyzed processes: selective oxidation, alkane activation, by product and waste minimization, selective synthesis, alkylation, olefin polymerization, alternative and renewable feedstocks
- **Enabling Science:** New catalyst design through combined experimental, mechanistic understanding, and improved computational modeling of catalytic processes. Development of techniques for high throughput synthesis of catalysts and clever new assays for rapid testing of small quantities of catalysts on diverse processes, and reduction of analytical cycle time by parallel operation and automation. Better techniques for catalyst characterization under actual operating conditions, particularly at high temperature and pressure (>1 atm). New methods to synthesize stable, high productivity catalysts with control of active-site architecture.
- **Reactor System Design and Scale-up:** Establish better procedures for characterizing the operation of lab, pilot and plant reactors and cross correlating their behavior. Develop more efficient methods to obtain physical, chemical, and transport property data for input into and verification of models.
- **Novel Reactors and Process Intensification:** Development of nonstandard reactors is dependent on advances in fundamental research and enabling technologies. Research areas include intensified reactors, rapid heating and cooling techniques, structured contacting, external field-assisted and photochemical reactions, and reactors for extreme conditions. Enabling technologies include new materials development, systems integration, micro-scale properties and phenomena determination, multistage design capabilities, and self-assembling reactor development
- **Computations** Develop powerful computational models that can accurately simulate the product yields and process dynamics in real life systems.
- **Cross-cutting technologies:** See below (*).

Separations

- **Adsorbents:** New materials with improved selectivity and stability and more favorable geometries, tools to predict adsorbent performance and aid in process design, and demonstration of commercial feasibility.
- **Crystallization:** Physical property data and molecular modeling capability for solid/liquid equilibrium and crystal growth mechanisms, and instruments to measure degree of super-saturation.
- **Distillation:** Improved understanding of physical phenomena, better in situ sampling, analytical and flow-visualization methods, and better predictive modeling tools.
- **Extraction:** New solvents, a better understanding of the fundamental physical processes, and an enhanced physical property database.
- **Membranes:** Economic evaluations to direct research efforts, membrane system development to enhance operability and robustness, new membrane materials, increasing surface area at lower cost, and predictive models.
- **Separative Reactors:** New materials, economic evaluations to prioritize applications for separative reactors, and improved design capabilities.
- **Ion Exchange:** New materials with greater selectivity, improved regeneration methods, lower cost materials, innovative ion exchange equipment, and hybrid systems.
- **Bioseparations:** Development of robust biocatalysts; development of better separations technologies with emphasis on membranes, extractants, adsorbents, and hybrid systems; obtaining physical properties data; extending predictive models; pursuing in vitro synthesis; and development of closed-loop fermentation processes.

- Materials: Develop improved cost-effective materials that have improved physical properties as well have improved thermal and chemical stabilities in harsh and corrosive environments.
- 1. Sensors and Controls: Develop systems that integrate sensor data to allow for the optimization of systems on a real-time basis.
- Dilute Solutions: Improved understanding of physical phenomena and intermolecular chemistry, enhanced physical properties databases, better predictive modeling tools, and improved separations technologies including hybrid systems.
- Cross-cutting technologies: See below (*).

Alternative Feedstocks

TBD

*Cross-cutting technologies: Major research needs that cut across several or all of the technical areas fall into four technical categories: experimental tools, modeling and property estimation, sensors, and system integration. Improved experimental tools are needed to design and operate reaction engineering systems more efficiently and to provide input data for models. These include better designs for laboratory-scale reactors and better experimental techniques for screening of synthesis methods and for developing a fundamental understanding of plant system operations. Fundamentals-based models are needed to support design and operation of reaction engineering systems. Thermophysical, thermo-chemical, and transport data that describe complex systems are needed for input into and validation of these models. Fast, precise, robust, online sensors are needed for data collection, monitoring, and process control. Integration of all these research capabilities into a systems approach is required to develop viable production reactors for industry. There is a need for better integration of models and experimental data gathering as well as models which couple process chemistry with process modeling. Ultimately, design and optimization tools are needed which will link process conditions to product properties at the micro-, meso-, and macro-scales. and new products to market, Develop capability to determine application enabling properties (modeling, synthesis, characterization & functional testing)

Chemicals Bandwidth Analysis

The Chemicals subprogram has completed the analysis of 50 top commodity chemicals that have the largest production, and the report has been published on the Chemicals website.

Background

The forest products industry is based on wood as a renewable and sustainable raw material. The industry produces thousands of products from renewable raw materials that are essential for everyday needs in communication, education, packaging, construction, shelter, sanitation, and protection. The U.S. forest products industry is made up of two major categories: Paper Manufacturing (NAICS 322) and Wood Product Manufacturing (NAICS 321). These industries are grouped together because they both rely on the nation's vast forest resources for raw materials and many companies that produce paper also produce lumber and wood products in integrated operations. The United States is the world's leading producer, consumer and exporter of pulp, paper and paperboard products. In 2003, it produced 90 million tons of paper and paperboard (25% of world production), which is equivalent to over 700 pounds for every man, woman, and child in the United States. The U.S. is also the leading producer of lumber and wood products used in residential construction and in commercial wood products such as furniture and containers. With total shipments valued at about \$283 billion a year, the industry directly employs nearly one million people in over 44,000 facilities. The industry is especially important in many rural economies where the local paper or lumber mill can be the area's largest employer.

The forest products industry consumes about 12% of domestic manufacturing energy use (Pulp and Paper 2.36 quads, Wood Products 0.38 quad (MECS 2002)), and ranks behind only chemicals and petroleum in its energy consumption. Although the industry self-generates more than half of its energy need by burning wood residuals and spent pulping liquor (black liquor) to generate steam and power, is still the third largest user of fossil energy in the U.S. manufacturing sector. The forest products industry also generates more than 2 billion tons of waste each year – mostly in the form of non-hazardous waste water and sludge. The industry practices recovery and recycling in its operations and its forests help the global carbon balance by sequestering carbon dioxide from the atmosphere. The industry also contributes to land management and natural resource conservation.

ITP's pulp and paper energy bandwidth analysis reveals opportunities for savings (compared to today's best available technologies) of 57% for paper drying and 27% for liquor evaporation during chemical pulping.

The U.S. Department of Energy's Industrial Technologies Program (ITP) formed a partnership with the U.S. forest products industry to support collaborative, innovative R&D on forest products technologies, promote deployment of promising technologies, and encourage the implementation of best practices and state-of-the-art technologies that will help the forest products industry cut energy use, minimize environmental impacts and improve productivity.

Strategy

The program is focusing most of its R&D effort on reducing natural gas consumption because of industry's reliance on this increasingly scarce and expensive fuel. The Forest Products subprogram supports ITP's and EERE's goals by targeting the development of technologies which will reduce steam demand in a state-of-the-art pulp and paper mill by 15% by 2015. In non-integrated paper mills, steam is typically produced in natural gas-fired boilers; so reducing steam demand reduces natural gas use. In integrated mills, steam is primarily produced in black liquor fired Tomlinson boilers while the remainder is generated in biomass or natural gas-fired power boilers. Thus, reducing steam demand in integrated mills saves natural gas and reduces black liquor requirements.

Last updated: 5/5/2008

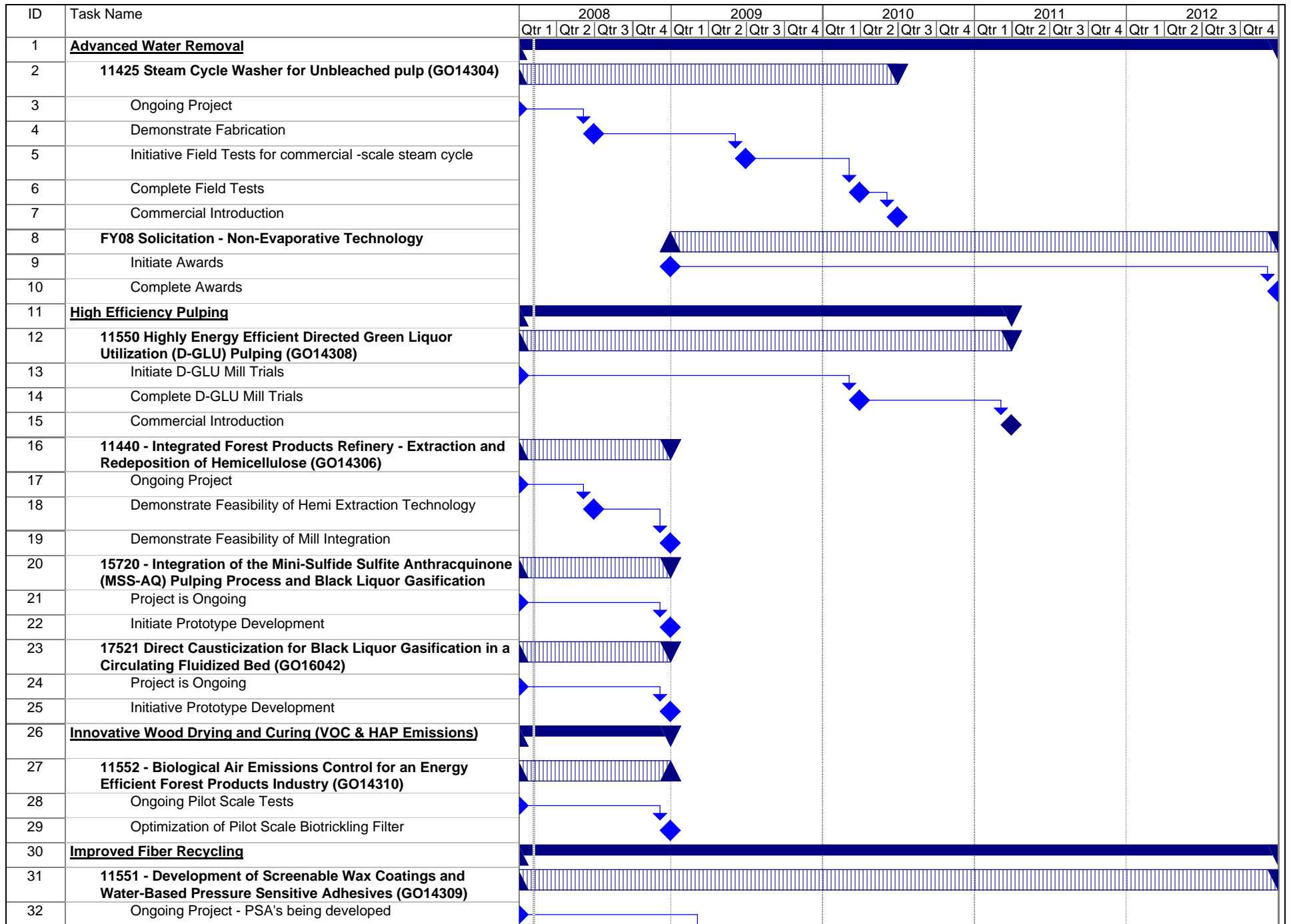


Developing black liquor gasification and biorefinery technologies are both EERE and industry priorities which become more economically attractive when less black liquor is required for steam generation. Reducing steam demand helps enable black liquor gasification because gasifiers typically produce 65% more electricity but 15% less steam than Tomlinson boilers. As a result, a mill that uses black liquor gasification must satisfy its steam requirements by reducing steam demand or by increasing its inputs of wood or other energy sources. Likewise, reducing steam demand makes the biorefinery concept more economically attractive because black liquor components (e.g. hemicelluloses), which are no longer needed to produce the steam, can be used as a feedstock for the biorefinery for no or low incremental cost. Thus, while ITP doesn't pursue direct R&D in the areas of gasification and the biorefinery, R&D investment in technologies to reduce steam demand will help enable these technologies.

ITP is currently funding projects that target significant technical barriers in the following four focus areas, but will concentrate most of its future effort in Advanced Water Removal and High Efficiency Pulping:

- **Advanced Water Removal:** This focus area aims to develop non-evaporative water removal technologies that will reduce the steam load for pulp and paper mills. Water removal through evaporation in the Forest Products Industry occurs in extremely energy intensive processes that consume over 600 trillion Btu/year of steam energy. Non-evaporative water removal technologies have the potential for being much less energy intensive.
- **High Efficiency Pulping:** This focus area targets the development of technologies that will reduce the energy intensity of chemical pulping. The Kraft chemical process is currently the dominant pulping process and uses approximately 725 trillion Btu/year (pulping and chemical recovery). This process uses heat and alkaline chemicals to remove the lignin that binds the cellulose fibers in wood. Wood chips are cooked in a digester and then the spent chemicals and lignin are washed from the pulp. This wash water or weak black liquor is then processed to generate steam and electricity and recover the pulping chemicals for reuse.
- **Innovative Wood Drying and Curing:** This focus area seeks to develop drying, curing, and VOC mitigation technologies that will reduce the energy intensity of the wood products sector. Energy is the highest wood processing cost and wood drying accounts for 50-80% of the wood products total manufacturing energy costs.
- **Improved Fiber Recycling:** This focus area targets the development of technologies that will increase the amount of fiber that can be recovered from waste paper. Recovered paper provides approximately 27% by weight of the fiber used for U.S. paper and paperboard production. Rising wood prices and land fill costs demand efficient processes for waste paper recycling.





ID	Task Name	2008				2009				2010				2011				2012			
		Qtr 1	Qtr 2	Qtr 3	Qtr 4	Qtr 1	Qtr 2	Qtr 3	Qtr 4	Qtr 1	Qtr 2	Qtr 3	Qtr 4	Qtr 1	Qtr 2	Qtr 3	Qtr 4	Qtr 1	Qtr 2	Qtr 3	Qtr 4
33	Development of new Benign Commercial PSA Labels																				
34	Continue with Development of Commercial Products (Post Project Period)																				

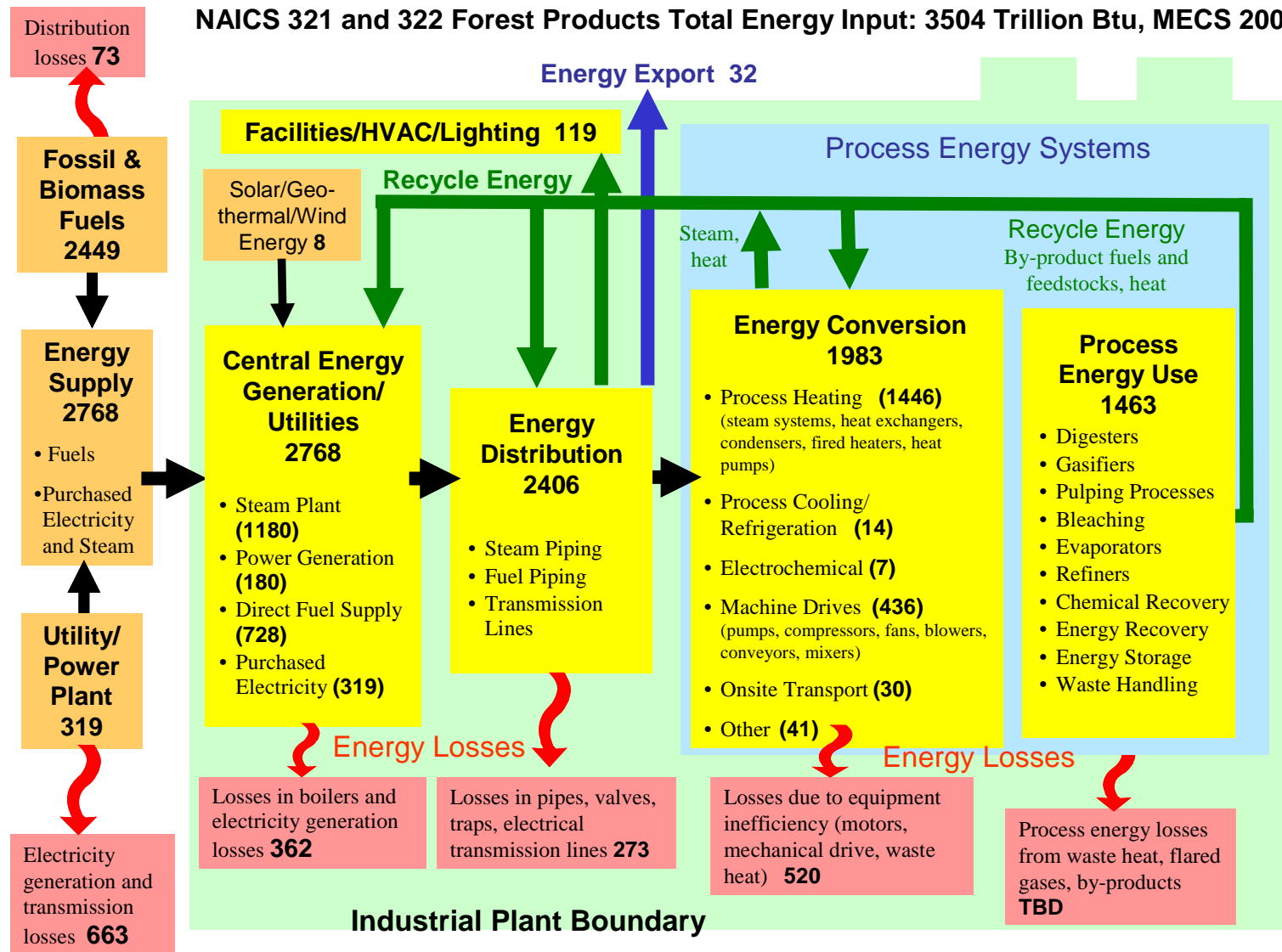
		<p>In FY08, the bleachability of pulp containing redeposited hemicellulose will be demonstrated in the 2nd quarter of FY08. In the 4th quarter of FY08, the feasibility of integrating the process of extraction and redeposition of hemicellulose into mill operation will be demonstrated and the results will transferred to industry and the technology will be considered for mill implementation. Final report is pending. <i>[Project Title: Integrated Forest Products Refinery (IFPR) --University of Maine & International Paper]</i></p> <p>2. Develop an alternative pulping process that reduces the energy intensity of chemical pulping by 20% and will replace the kraft pulping process.</p> <p>In FY08, the Mini-Sulfide Sulfite Anthraquinone (MSS-AQ) alternative pulping concept definition study will be completed. Final report is pending.</p> <p>Initiate prototype development in FY09 if concept definition study shows the technology to be technically/economically feasible. <i>[Project Title: Integration of the MSS-AQ Pulping Process and Black Liquor Gasification - NCSU]</i></p> <p>3. Develop an autocaustizing technology that is compatible with gasification.</p> <p>In FY08, the concept definition study to assess the feasibility of using titanates in a gasifier for autocausticization will be completed. Final report is pending.</p> <p>Initiate prototype development in FY09 if concept definition study shows the technology to be technically/economically feasible. <i>[Project Title: Direct Causticization for Black Liquor Gasification - GA Tech Research Corporation]</i></p>	<p>2. Demonstrate a reduction of energy intensity of chemical pulping by 20% in an alternative to the kraft pulping process.</p> <p><i>Total potential savings = 5 trillion Btu/year</i></p> <p>3. Demonstrate 75-95% conversion of fixed carbon in a black liquor-titanate mixture during gasification.</p> <p><i>Total potential savings = 6 trillion Btu/year</i></p>
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<p>Innovative Wood Drying and Curing</p> <p><u>Objective</u></p> <p>Develop technologies that will reduce the energy intensity of the wood products sector by 20% (saving 0.7 million Btu/ton of product).</p>	<ol style="list-style-type: none"> 1. Energy intensive Regenerative Thermal Oxidizers (RTOs) are currently used to control VOC and HAP emissions from industrial pulp, paper, and wood products processes. 2. Current technologies used to dry and cure lumber and wood composites are energy intensive. Current adhesives require temperatures in excess of 150 degrees F to cure. 	<ol style="list-style-type: none"> 1. Develop an alternative, energy-efficient wood drying technology to reduce VOC and HAP emissions. <p>In FY07, the field trials to implement strategies for drying and pressing wood without emission controls was completed and the results were disseminated to the project partners.</p> <p>In FY08, complete the field testing for the process improvements and biological control system. If the technology proves successful, it will be transferred to industry. <i>[Project Title: Biological Air Emissions Control for an Energy Efficient Forest Products Industry of the Future - Texas A&M University-Kingsville, Bio-Reaction Industries, LLC, Stimson Lumber Company]</i></p>	<ol style="list-style-type: none"> 1. Demonstrate an emissions technology or strategy that reduces the energy intensity of emissions control by 20% in a mill. <p><i>Total potential savings = 8 trillion Btu/year</i></p>
<p>Improved Fiber Recycling</p> <p><u>Objective</u></p> <p>Increase the amount of fiber that can be utilized or recovered from waste paper by 10%.</p>	<ol style="list-style-type: none"> 1. Gross contamination and mix of fiber types hinders fiber recycling (e.g. mixing of unbleachables with other fibers) 2. The strength of fibers is degraded during conventional recycling processes which limits the paper grades that can be used (or necessitates the use of larger percentages of virgin fiber) and reduces the number of times paper can be recycled. 3. Pressure sensitive adhesives (PSAs) and wax coatings are the most problematic contaminants faced by paper recyclers. Current PSAs and wax coatings cannot be separated efficiently and their presence causes numerous recycling problems. 	<ol style="list-style-type: none"> 1. Reformulate the chemical compositions of water-based PSAs and wax coatings to allow for these contaminants to be easily screened during the recycling process. <p>In FY07, new PSA formulations were developed and tested for screenability. For the wax coatings the correct mesophase behavior required to ensure removal of the wax coatings were identified will be investigated to determine how to optimize the wax coating.</p> <p>In FY08, the most promising candidates will be further developed with the help of end users to insure that they will be economically viable. If the reformulated wax coatings are easily screenable and economically viable, the technology will be transferred to industry. <i>[Project Title: Development of Screenable Wax Coatings and Water-Based Pressure Sensitive Adhesives – Univ. of Minnesota, Boise Cascade Corporation, Franklin International, The International Group, Inc]</i></p>	<ol style="list-style-type: none"> 1. Demonstrate a 10% increase in the economic recovery of recycled fiber at a recycled fiber mill.

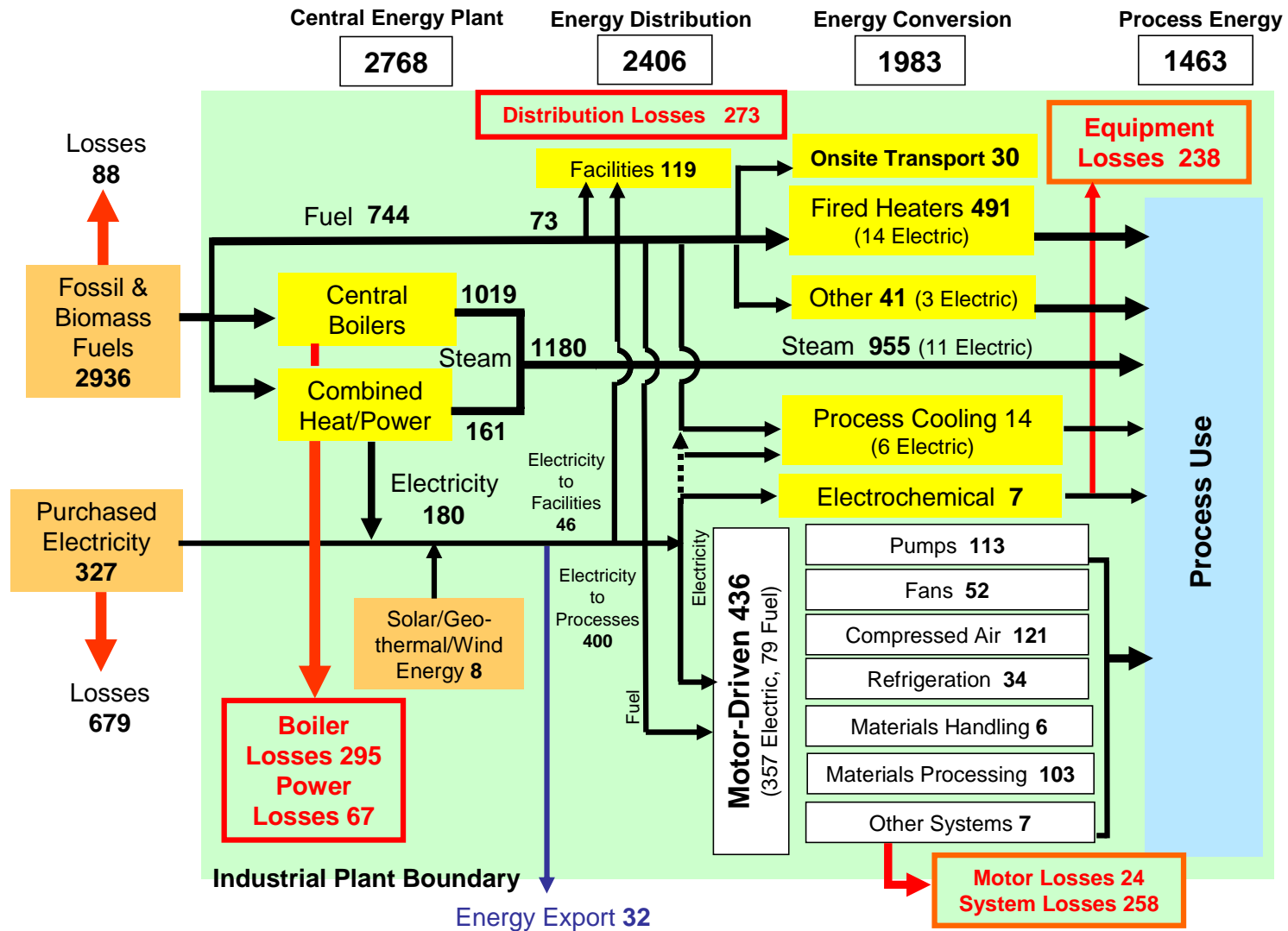
SOURCES:

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Setting the Industry Technology Agenda. The 2001 Forest, Wood & Paper Industry Technology Summit, TAPPI Press.
Energy and Environmental Profile of the U.S. Pulp and Paper Industry

NAICS 321 and 322 Forest Products Total Energy Input: 3504 Trillion Btu, MECS 2002



NAICS 321 and 322 Forest Products Total Energy Input: 3504 Trillion Btu, MECS 2002



Forest Products Industry Roadmap Summary

Advancing the Forest “Biorefinery” – Extracting Value Prior to Pulping

- Demonstrate biomass and black liquor gasification with syngas clean-up and processing to fuels/chemicals
- Demonstrate biomass and black liquor gasification with syngas cleanup and conversion to electricity
- Demonstrate pyrolysis/liquefaction technologies that can be utilized to replace fossil fuels in manufacturing plants (e.g., lime kiln fuel) while also producing value-added products or product intermediate streams (e.g., activated carbon or resins for oriented strand board manufacture)
- Develop a hemicellulose/sugar extraction process that will produce extract of sufficient concentration and composition to produce (through fermentation processes) profitable fuels and/or chemicals (e.g., ethanol & acetic acid)
- Develop a hemicellulose/sugar extraction process that will allow increased digester and/or recovery boiler throughput

Breakthrough Manufacturing Technologies

- Develop and use a better understanding of sheet dewatering to cost-effectively increase solids before drying to the theoretical limit without compromising sheet structure
 - Alternatives to press dewatering
 - Avoid sheet reuptake of water (e.g., one-way press)
 - Extend current pressing limits
 - Alternatives to vacuum technology
- Develop next generation technologies that improve energy transfer to the sheet for drying
 - Improve mass transfer
 - Increase cross-directional moisture uniformity
- Develop novel variations on the sulfur chemistry of the traditional Kraft process, especially as facilitated by black liquor gasification
 - Polysulfide pulping
 - Splitting of sodium and sulfur
 - Tradeoffs between time, temperature, capital cost, and concentration during cooking
 - Explore impacts on fiber dewatering and quality of paper products from higher yield processes
 - Explore potential for black liquor gasification and sulfite pulping to enable replacement of current causticizing process
- Develop alternative to refining as a way to generate bond strength that is more energy efficient and cost effective, without compromising drainage or formation
 - Effects of reintroducing extractable wood constituents and redeposition on pulp (e.g., hemicellulose)
 - Modification of fibers or fiber surfaces with additives, enzymes, or biological or chemical treatments
 - Alternative materials to cellulose fibers
 - Modification of fibers to enable higher filler levels
 - Increase the modulus of elasticity
- Develop novel materials and material additives that deliver strength and optical properties at lower cost than fiber (better filler/improved pigments)
 - Innovative, low-cost materials and/or processes to improve filler-fiber bonding
 - Innovative, low-cost materials and/or processes to improve pigment coating bonding
 - Bio-based pigments and coatings
- Develop full auto-causticizing technology
 - Better understanding of autocausticizing reagent properties

<ul style="list-style-type: none"> – Concept definition studies – More concentrated alkali (white liquor) stream – Pilot-plant demonstrations • Evaluate a process approach that would integrate multi-technology selective separation processes <ul style="list-style-type: none"> – Electromechanical separations – Mechanical or membrane separations for partial dewatering – Liquid-liquid separations – Thermal separations – Lignin separation earlier in the process • Develop energy-efficient mechanical defiberization processes, including radical alternatives (e.g., microwave, ultrasonic) <ul style="list-style-type: none"> – Polysulfide pulping • Develop application of non-sulfur chemistries, such as enzyme pretreatment, soda-AQ, chemical (e.g., solvents), biological, and borate • Develop simplified, energy-efficient bleaching process (e.g., in chemicals used)
<p><u>Advancing the Wood Products Revolution</u></p> <ul style="list-style-type: none"> • Develop more energy-efficient technologies for wood-based product manufacturing <ul style="list-style-type: none"> – Moisture-activated or non-heat activated adhesives – Reduce drying time for woodbased materials • Reduce manufacturing VOC and HAP emissions of wood-based products <ul style="list-style-type: none"> – Methods to trap and burn VOCs – Reduce press emissions
<p><u>Next Generation Fiber Recycling & Utilization</u></p> <ul style="list-style-type: none"> • Trial full-scale demonstrations of existing and prospective sorting equipment to evaluate performance, cost, rapidity of implementation, and overall efficiency. Establish performance and cost efficiencies. Consider basic engineering to understand how to effectively combine and fit new equipment into existing systems and structures • Further develop and trial handling methods/systems for recovered paper (may include shredded paper) so that both volume and rate of speed during sorting are increased to significantly lower costs and maximize throughput • Develop novel approaches to repulp and clean fibers from recovered paper that will lower energy use, reduce water consumption, allow the use of “dirtier” paper (lower cost), and limit the number of “operations” required • Develop and trial technologies to remove other recyclables and gross contaminants (e.g., plastic, glass, metal, organic materials, etc.) from recovered paper through mechanical and/or sensor methods • Discover fundamental mechanisms that cause separation of fiber types and contaminants. Use this knowledge to develop breakthrough technologies that improve product quality, productivity, and paper manufacturing runability
<p><u>Positively Impacting the Environment</u></p> <ul style="list-style-type: none"> • Develop sulfur-free pulping technologies that can be economically integrated into the mill • In-process capture, extraction, and fixation of VOCs, HAPs, and PM from wood products facilities

2.1.4

Metal Casting

Background

The U.S. metal casting industry is crucial to the U.S. economy and national security because it produces critical components that keep the automotive, defense, and energy sectors competitive in world markets. For instance, metal casters enable the automotive sector to produce lightweight, high strength components while meeting the need for safety and fuel efficiency. Lightweight, complex-shaped metal castings also play a critical role in military applications such as F22 fighter jets and the Seawolf nuclear submarines. Metal castings also represent critical components in power generation, oil and gas, and mining equipment. The majority of metal casters are small businesses (94% employ less than 250 people, 80% less than 100), often lacking the resources to perform research without collaborative efforts such as that facilitated through ITP. This industry is located in every state in the United States, with 2,190 foundries employing an estimated 220,000 people.

The metal casting industry consumes an estimated 257 trillion Btu annually. This includes 165 trillion Btu consumed by metal casters classified under NAICS 3315 plus an estimated 92 trillion Btu consumed in captive foundries. This is over a 21 percent decrease in the industry's energy consumption in 1998, when it was estimated that the industry consumed 328 trillion Btu. This decline is attributed to a 26.6 percent reduction in tonnage shipped when comparing 1998 to 2002 because a number of metal casters went out of business.

The metal casting industry utilizes a variety of fuels and electricity to meet its energy needs. In 2002, forty-seven percent of the industry's energy consumption is supplied by natural gas and 33% from electricity. The remainder includes other fuel sources such as coke and breeze (coke is a solid carbonaceous residue derived from low-ash, low-sulfur bituminous coal used as a fuel and reducing agent in smelting iron ore; breeze is the fine screening from crushed coke most often used as a fuel source in the process of agglomerating iron ore.) In 2002, the industry spent \$1.3 billion on purchased fuels and electricity. Major energy-consuming processes in metal casting include: melting, coremaking, moldmaking, heat treatment, and post-cast activities. The most energy-intensive of these processes is melting, which accounts for an estimated 55% of process energy costs (but varies by casting process). *ITP's analysis indicates that the energy intensity of melting processes (induction, cupola, and reverb) used in the casting industry could be reduced 20-50% through technological advances.* Major melt energy savings can occur by improving the efficiency of the melting process and by improving the efficiency of the overall process from design to post cast.

The Industrial Technologies Program Metal Casting activity has shown strong progress in making energy efficiency improvements in major areas of the casting process. For example, through improved design tools, advances in the understanding of material properties, and revolutionary process improvements, metal casters are increasing yield and reducing rejection rates thereby reducing the amount of metal that must be melted per ton of casting produced. The program has accelerated the adoption of the lost foam casting process; it is enabling metal casters to adopt new 'risering' and 'gating' practices to increase yield; and it is working with the industry and other EERE programs to deliver energy audits, BestPractices and other methods for saving energy in the near term. These activities contribute directly to DOE priorities to revolutionize the Nation's approach to energy efficiency.

The Metal Casting IOF will further strengthen its focuses on two parallel and closely related pathways: Advanced Melting, and Innovative Casting Processes.

Strategy

This multi-year strategy reflects both the existing metal casting sub-program mortgages and the DOE proposed FY08 metal casting sub-program budget. Within this proposed budget, the sub-program reflects a strong tilt towards near term energy saving technologies that can be applied commercially within the next 5 to 7 years.

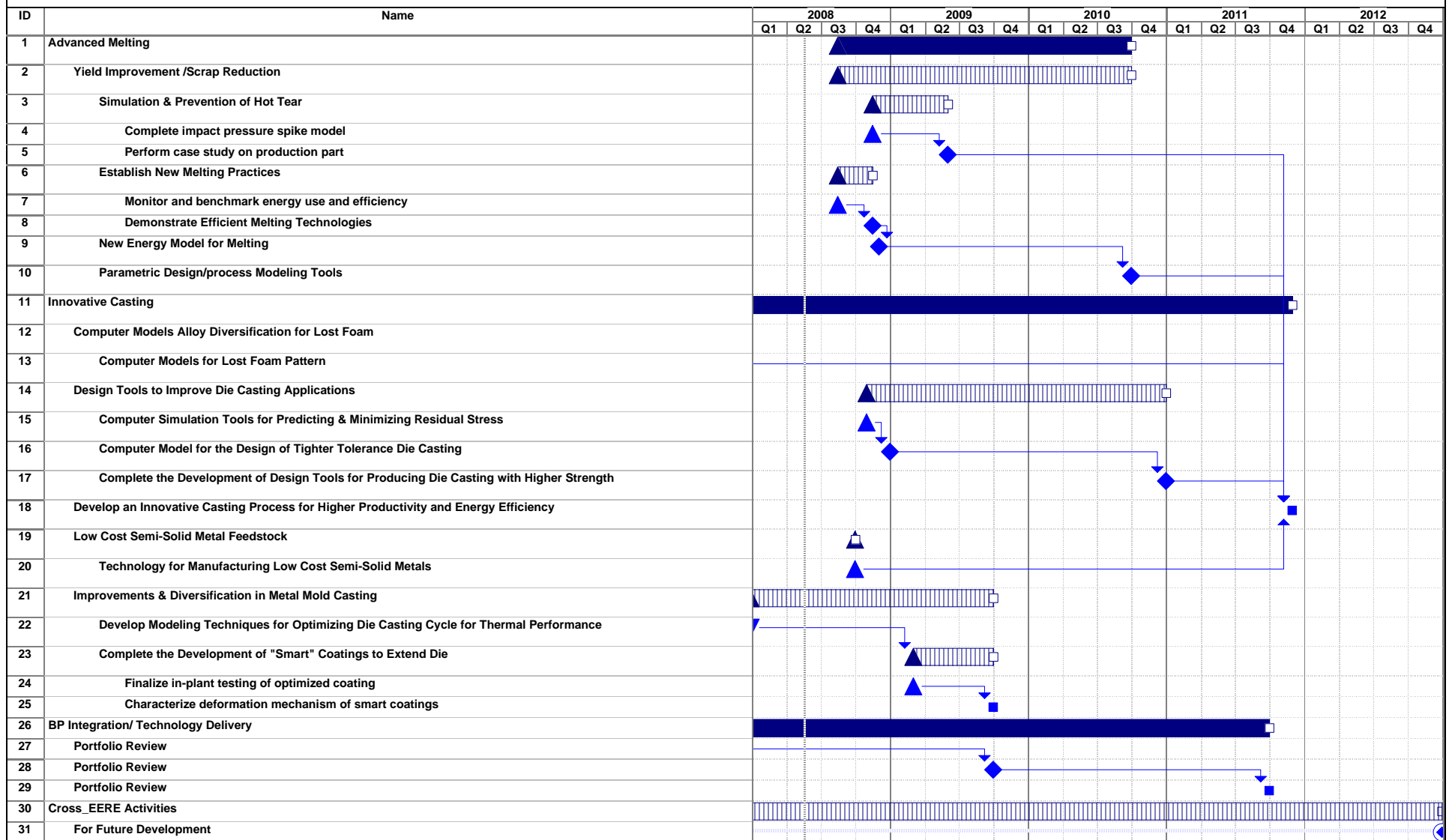
The funded activities are university-based, mainly addressing the high priority research needs described in the *Metalcasting Industry Technology Roadmap: Pathway for 2002 and Beyond*. It focuses on two areas: Advanced Melting Technologies, and Innovative Casting Technologies. The former are activities aimed at reducing scraps and improving yields of castings, and improving melting practices in general. The latter are activities aimed at improved casting design methodologies for the wide array of casting alloys and process possibilities, improved properties data, and simulation tools that predict defects. When these tools are made available to the metal casting industry there will be a significant impact on energy savings across many industries.



Last updated: 5/5/2008



Metal Casting



Metal Casting Focus Area	Barriers	Pathways	Metrics
<p>Advanced Melting (1)</p> <p>[Research will develop new design methodologies and establish new melting practices to increase yield of steel castings by 10% and thus reduce the energy consumption in melting by 10% (saving 1.4 million Btu/ton of steel cast).</p>	<ul style="list-style-type: none"> • <i>Lack of parametric design capabilities</i> (3) [Parametrics in design tools allow changes in one parameter to adjust an entire model accordingly. Design tools with this capability facilitate casting weight and revert reduction, both large factors in casting process energy.] • <i>Lack of efficient scheduling and production techniques, such as alloying and furnace controls, that can reduce or eliminate energy intensive processes.</i> (4) [Scheduling and production techniques are essential tools in optimizing energy intensive molten metal handling.] 	<p>1. This pathway centers on computer modeling for predicting defects in steel castings, which will enable the re-writing of new standards for feeding rules, x-ray inspection, and unconventional methods for casting parts. In FY2008, researchers will develop measures to reduce at least 5% scraps incurred by "hot tears" in steel casting production. [Casting designers can use these measures to predict where hot tears are likely to develop in a steel casting and what techniques can be implemented to prevent these hot tears.] In FY2009 methods and procedures will be established for measuring energy use in metal melting and handling operations; By 2011 an energy-efficiency model of steel foundry operations will be developed for measuring energy use in melting and handling. These developments will provide in part, a knowledge base needed to develop an innovative casting process with 20% higher productivity and efficiency in 2015.</p>	<p>Demonstrate a 10% increase in "True Yield" in steel castings in production runs. <i>Total potential savings = 40 trillion Btu/year.</i></p> <p>["True Yield" is the weight of 'good castings' produced divided by the total weight of poured metal, expressed as a percent.]</p>
<p>Innovative Casting Process (2)</p> <p>Advance casting processes by developing simulation tools; low cost semisolid feedstocks; and capabilities to cast different alloys; to increase yield and reduce scrap.</p>	<ul style="list-style-type: none"> • <i>Lack of integrated design modeling tools for the various metal casting processes.</i> (5) [An integrated modeling tool will show the relationship between material properties, the specific casting process parameters, and impact on casting geometry. Inclusive of "parametrics" above, this kind of tool will drive casting weight and revert reduction.] • <i>Limited control of the variability in dimensions and material properties of castings.</i> (6) [Improve consistency of as-cast dimensions and casting microstructure to optimize machining stock. Reduced machine stock will reduce tons melted.] 	<p>1. In the <i>Computer Models and Alloy Diversification for Lost Foam</i> pathway, researchers will develop a simulation tool to model pattern displacement which occurs during the metal pouring stage in FY2008. These developments will provide in part, a knowledge base needed to develop an innovative casting process with 20% higher productivity and efficiency in 2011.</p> <p>2. Research in the <i>Design Tools to Improve Die Casting Applications</i> pathway will develop simulation tools for predicting and minimizing residual stress in die castings in FY2009. Based on all the development work thus far, research will complete the development of design tools for producing die castings with higher strength in FY 2012 and will provide in part, a knowledge base needed to develop an innovative casting process with 20% higher productivity and efficiency in 2013.</p> <p>3. <i>The Low Cost Semi-Solid Metal Feedstock</i> pathway will</p>	<p>Demonstrate a 10% increase in "True Yield" in lost foam castings in production runs.</p> <p>Demonstrate an 8% increase in "True Yield" in die castings in production runs.</p>



Metal Casting Focus Area	Barriers	Pathways	Metrics
	<ul style="list-style-type: none"> • <i>Lack of new, efficient casting processes for high volume nonferrous and ferrous castings.</i> (7) [60% of castings are produced using the green sand process. Past and current research has shown alternative methods that result in casting weight and revert reduction.] • <i>Lack of thermal management capabilities including measures to control the rate of heat extraction during solidification processes.</i> (8) [Better thermal management will create higher integrity, thinner wall, and higher strength castings.] • <i>Processes for casting magnesium need improvement to meet market requirements for structural performance, light weighting, and volume.</i> (9) [Magnesium castings are generally limited to nonstructural components. Strength improvements will allow the transportation sector to better apply this alloy's weight savings capability -- only 9.5 lbs in 2002 automobiles.] • <i>Design engineers need data based on solidification rates and alloy microstructure for allowable high-cycle fatigue stress.</i> (10) [Reliable data on solidification rates and casting fatigue will enable more casting designs in engineered components. Alternatives to the casting process consume more energy.] • <i>The capability is needed to prototype</i> 	<p>provide the casting industry with a new, efficient casting process for nonferrous castings, and provide control of the variability in the material properties of Rheocastings. This "toothpaste" like flow instabilities, typically observed in the SSM processing, limit the production rate and reduce the final quality of castings. In FY2008, a technology for manufacturing low cost SSM feedstocks will be developed. These developments will provide in part, a knowledge base needed to develop an innovative casting process with 20% higher productivity and efficiency in 2011.</p> <p>4. The Improvements & Diversification in Metal Mold Casting pathway will develop a model to prototype permanent mold castings that can meet the dimensional tolerance and casting integrity. Research will develop optimized multi-layered coatings and application methods for improved tooling performance in FY2008. [Result of this work will provide guidelines and processing parameters for commercial coating suppliers to produce the optimized coating structure.] Research will continue in modeling techniques for optimizing die casting cycle for thermal performance and develop improved productivity through innovative die cooling techniques in the next three years. [These techniques will assist in designing tooling with cooling lines to distribute the temperature more uniformly and result in less distortion, thus increasing productivity. The new guidelines for cooling line size and distance from the die cavity surface will be generated to increase the solidification rate and productivity.] Research will then continue down this pathway and complete the development of a smart coatings extend die life by over 10% in FY 2012. These developments will provide in part, a knowledge base needed to develop an innovative casting process for 20% higher productivity and efficiency in 2015.</p>	<p>Lower the cost of producing one pound of SSM feedstock to \$1.20 - \$1.36, from current cost of \$2.25 (i.e. 40 to 47% reduction in cost/lb).</p> <p>Demonstrate an 8% increase in "True Yield" in permanent mold castings.</p> <p><i>Total potential savings for Innovative Casting Process focus area = 25 trillion Btu/year</i></p>



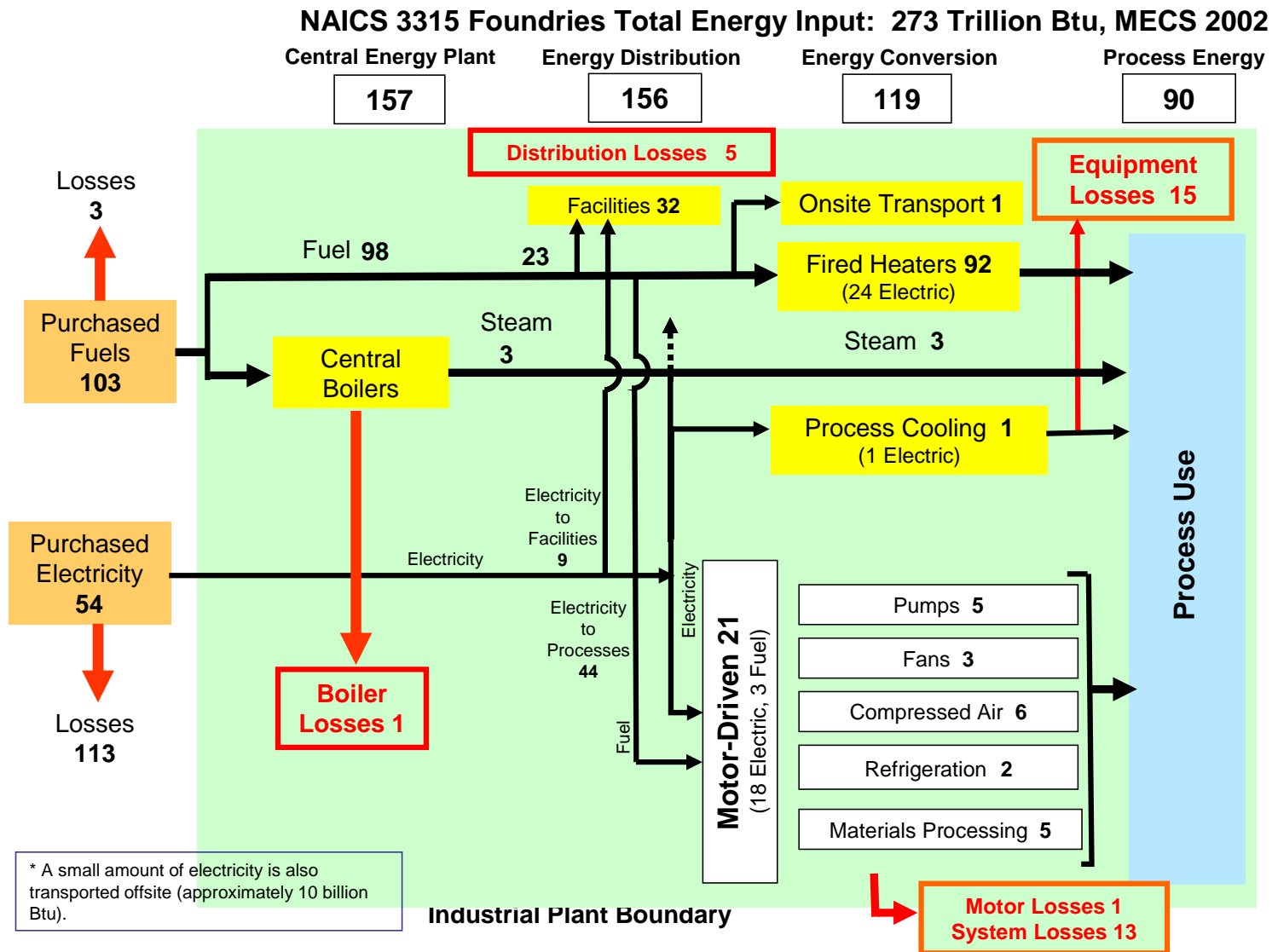
Metal Casting Focus Area	Barriers	Pathways	Metrics
	<p><i>permanent mold castings that are faithful to production dimensional tolerance and casting integrity. (11) [Prototype processes are needed that duplicate permanent mold casting solidification rates. Prototype castings must be dimensionally and structurally similar to their permanent mold production counterparts.]</i></p>		

Sources:

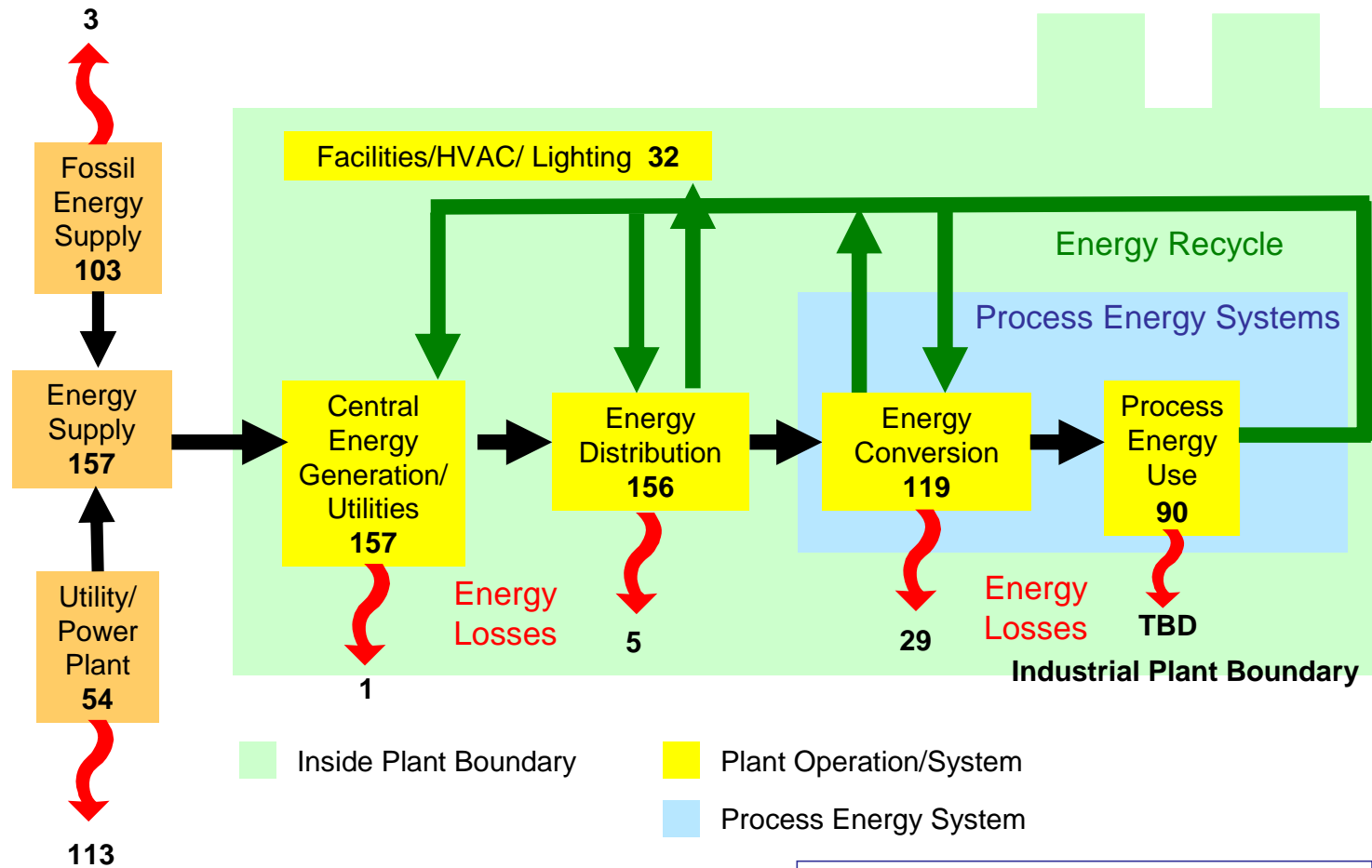
- (1) U.S. Department of Energy, Energy Efficiency and Renewable Energy, Office of Industrial Technologies, Metal Casting Industry of the Future, *Energy and Environmental Profile of the U.S. Metal Casting Industry*, Washington DC, September 1999, pg. 10.
Note: In order to overcome the lack of parametric design capabilities the Metal Casting IOF is funding research establishing new design methodologies that will significantly improve the energy efficiency of melting. Current research is focusing on the downstream process of steel casting design and production. The essential approach is to use computer modeling for defect prediction in steel castings in the design stage before actual castings are made. Production yield can be increased significantly with this approach.
- (2) U.S. Department of Energy, Energy Efficiency and Renewable Energy, Office of Industrial Technologies, Metal Casting Industry of the Future, *Energy and Environmental Profile of the U.S. Metal Casting Industry*, Washington DC, September 1999, pg. 10.
Note: Research in this focus area will be conducted on four different pathways that will lead to the goal of developing an Innovative Casting Process for higher productivity and energy efficiency. The four pathways are:
 - Computer Models and Alloy Diversification for Lost Foam
 - Design Tools to Improve Die Casting Applications
 - Low-Cost Semi-Solid Metal Feedstock
 - Improvements and Diversification in Permanent Mold Casting.
- (3) Cast Metals Coalition, *Metalcasting Industry Technology Roadmap: Pathways for 2002 and Beyond*, October 2003 pg. 17
- (4) Cast Metals Coalition, *Metalcasting Industry Technology Roadmap: Pathways for 2002 and Beyond*, October 2003 pg. 23
- (5) Cast Metals Coalition, *Metalcasting Industry Technology Roadmap: Pathways for 2002 and Beyond*, October 2003 pg. 16
- (6) Cast Metals Coalition, *Metalcasting Industry Technology Roadmap: Pathways for 2002 and Beyond*, October 2003 pg. 12
- (7) Cast Metals Coalition, *Metalcasting Industry Technology Roadmap: Pathways for 2002 and Beyond*, October 2003 pg. 22
- (8) Cast Metals Coalition, *Metalcasting Industry Technology Roadmap: Pathways for 2002 and Beyond*, October 2003 pg. 25
- (9) Cast Metals Coalition, *Metalcasting Industry Technology Roadmap: Pathways for 2002 and Beyond*, October 2003 pg. 22
- (10) Cast Metals Coalition, *Metalcasting Industry Technology Roadmap: Pathways for 2002 and Beyond*, October 2003 pg. 11
- (11) Cast Metals Coalition, *Metalcasting Industry Technology Roadmap: Pathways for 2002 and Beyond*, October 2003 pg. 13



2.1.4.1 Metal Casting Footprint



NAICS 3315 Foundries Total Energy Input: 273 Trillion Btu, MECS 2002



* A small amount of electricity is also transported offsite (approximately 10 billion Btu).



2.1.4.2 Metal Casting Roadmap Summary

The U.S. metal casting industry developed its second roadmap in early 2003. This roadmap discusses important challenges that are common to the industry. These challenges include the need to:

- Accelerate the rate of change among metalcasters. To accomplish this, the industry must increase training and technology transfer and motivate metalcasters to adopt new advances and technologies
- Identify and prioritize factors that reduce variability and develop measures to reduce their occurrences.
- Ensure casting quality and performance at the design stage. Incorporate and improve Advance Quality Planning (AQP), Design Failure Modes Effect & Analysis (DFMEA), and Process Failure Modes Effect & Analysis (PFMEA)
- Develop measures to improve process control in casting operations.
- Improve the efficiency and control of melting processes, which includes upstream metal preparation and downstream molten metal handling.
- Develop standards for quantitative measurement of internal and external casting quality attributes based on objective structural performance and superficial appearance requirements.
- Develop more economical processes for producing castings in an oxygen/contaminant-free environment.
- Improve automation in the casting processes and reduce the number of process steps.
- Improve safety performance and reduce environmental impact.
- Develop new pattern materials with less carbon content for lost foam casting.
- Develop the capability to produce mis-run-free, thin-wall castings.

Research projects funded under the focused areas “Advanced Melting” and “Innovative Casting” are formulated to meet most of the challenges listed above.

2.1.4.3 Metal Casting Bandwidth

Theoretical/Practical Minimum Energy Study: KERAMIDA Environmental, Inc. (Columbus, Ohio) recently conducted a study to evaluate energy requirement for various metal casting processes. This study evaluates the theoretical minimum and practical potential for reducing energy requirements, to produce one ton of molten metal in metal casting operations. This study examines several casting processes including: green sand, chemically bonded sand, lost foam, investment, permanent mold, and die casting as well as melting processes, including cupola, electric induction, electric arc, gas-fired crucible, and gas-fired reverberatory furnaces.

The theoretical minimum for each process or operation is defined as the absolute theoretical minimum energy required without regards to energy loss or practical operational consideration. The best practice minimum energy requirement for each process takes into account what is possible under actual operational conditions utilizing best practices in the industry. The practical minimum energy requirement is the actual minimum energy usage being achieved in practice in industry. Furthermore, potential waste heat recovery options are identified, and the influences of scrap levels and yield on energy requirements are evaluated for each named process.



2.1.5

Background

The U.S. steel industry is now being transformed through its most significant restructuring in modern times. More than 30 steel companies declared bankruptcy since 1999. During this time, the industry has shuttered most of its corporate research facilities and eliminated their staffs. Numerous acquisitions have taken place, and many well known company names have vanished. Over the last five years, however, the pace of industry production has increased and an industry once fighting for survival is now able to implement process improvements, especially in energy efficiency, though relying on suppliers and outside researchers to develop these technologies. The ITP steel sub-program reflects the twin realities of eliminated research capability and the industry's ability to commission new, more energy efficient steel process technologies. But, a new threat has emerged in the form of the "BRIC" nations, Brazil, Russia, India and China. In China especially, low labor costs and government policies have enabled China to emerge as a major user, producer and worldwide marketer of steel. Industry restructuring is in part a result of this intense worldwide competition. This competition has required that U.S. producers minimize major cost elements and adopt the most efficient production technologies, especially energy-efficient technologies, in order to survive. However, the "pipeline" of new ironmaking and steel production innovations has been depleted due to the previous industry difficulties. The industry needs to become even more efficient to remain competitive with aggressive foreign suppliers. Even though they are now profitable, steel companies do not have the financial resources and facilities to conduct needed process research and development. The industry is looking to DOE-ITP to catalyze a resurgence in the creation of new cost and energy efficient technologies.

Electric arc furnace (EAF) steelmakers have steadily taken market share (mostly the lower graded products) from the large integrated steelmakers. EAF production now accounts for well over 50 percent of domestic production. However, increases in both steel scrap prices and electric rates, and higher natural gas prices have hurt the EAFs. EAF steelmakers face additional challenges, including the high cost and limited availability of suitable steel scrap and direct reduced iron to feed their furnaces.

To survive in the long term, integrated mills need cost cutting technological advances that will make them more competitive globally. *ITP's steel energy bandwidth study reveals that today's steelmaking processes use at least 40% more energy than practically required.* Energy studies show that advances in steelmaking processes that eliminate coke and use less raw materials, electricity, and other fuels can yield energy savings of 18 percent.

Strategy

This multi-year strategy reflects both new FY08 steel activities and multi-year mortgages. Within this proposed budget the portfolio supports both energy saving technology that can be applied commercially within the next three to five years and high risk energy saving innovations (early stage-gate) that could be applied after 2015.

Two projects started as part of the AISI Technology Roadmap Program (TRP) are continuing. The TRP focuses on two topics: Yield Improvement and Breakthrough Technologies. The former are activities that minimize energy and material input without significantly changing the existing steelmaking process. The latter are early stage-gate projects now conducted by universities that could result in new steelmaking processes. These projects, co-sponsored with AISI, will be completed by the end of FY 2008. In addition to these, three other projects are considered to be late stage gate (Stage 3 or 4). One project is implementing a concept for reheating furnaces that minimizes scale formation on steel during reheating. Another project is pilot stage testing a new concept for making high quality iron using coal as the reductant. The third is a new project selected from the FY 2007 solicitation that aims at improving blast furnace efficiency through optimization of the charge material distribution.

There currently are two production routes for making steel:

Integrated Production

- Iron ore is fed into blast furnaces to produce liquid iron, which is then fed into oxygen furnaces to make steel

Electric Arc Furnace-Based

- Scrap and scrap substitutes are re-melted



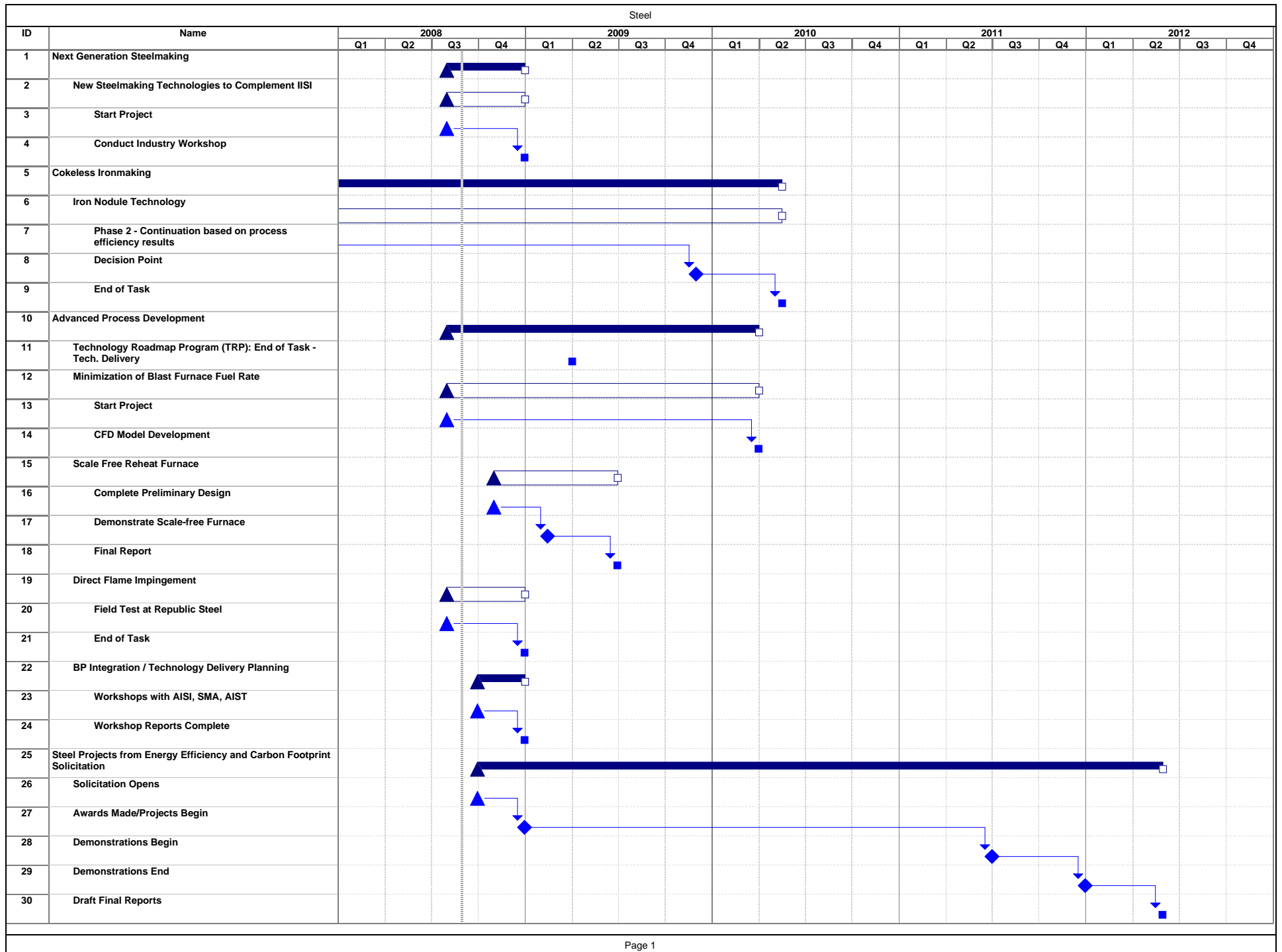
It is essential that ITP continue its relationship with industry associations and their members. Indeed, it is important that these groups participate in a stakeholder workshop for portfolio development which will guide future ITP steel activities and establish its next generation of priorities. It is expected that this workshop will occur in FY'08.

The FY'08 "Collaborative Energy Efficiency and Carbon Footprint" industry solicitation which will include steel, notes elements that can be incorporated into a future, more efficient and ultimately significantly different integrated steel making facility. The energy efficiency of steel production has increased with time, and more low cost, energy efficient mills are seeking routes to producing higher quality steel while continuing to maintain their traditionally low costs. It can be expected that new generation integrated facility will be able to produce high quality steel at a considerably lower cost and use less energy per ton produced than current generation integrated mills. To supply "iron units", this facility could incorporate a traditional, but more efficient blast furnace, or a direct reduced iron process. Steelmaking could be accomplished in a number of vessel types using traditional or pioneering processes. Specific elements that can be integrated into this overall activity are:

1. New or improved alternative ironmaking technologies, including direct reduced iron (DRI) technologies that have high potential to replace the blast furnace ironmaking process.
2. Technologies to improve the energy efficiency and reduce the carbon footprint of equipment currently used in energy-intensive process steps such as blast furnace iron making, basic oxygen steelmaking, electric arc furnace steelmaking, reheating, hot rolling, annealing, coating, etc.

Last updated: 5/5/2008





Steel Focus Area	Barriers	Pathways	Metrics
Next Generation Steelmaking <u>Objective</u> Develop revolutionary new steelmaking concepts that dramatically reduce energy intensity and carbon footprint.	<ul style="list-style-type: none"> Current batch steel operations result in energy losses associated with transfer operations as well as operation of the processes themselves. Current processes necessitate external heating to the raw materials, requiring lengthy heating times at high temperature to effectively transfer heat to the center of the material mass. Significant energy is thereby lost to the exhaust gas because of the high volume of air flow required by combustion. 	1. Conduct industry workshop to identify ideas for transformational technologies (Q4-FY08).	1. Reduce energy per unit of steel produced 12% (from 15.9 MBtu/ton to 14.3 MBtu/ton of steel for integrated steelmaking, and from 6.8 MBtu/ton to 6.0 MBtu/ton of steel for scrap-based steelmaking). <i>Total potential savings = 50 trillion Btu/year</i>
Cokeless Ironmaking <u>Objective</u> In the future, cokeless iron making processes will convert iron ore into iron of the same quality as the pig iron produced by blast furnaces, be more energy efficient and have an overall lower cost.	<ul style="list-style-type: none"> Higher grades of steel require higher quality iron. The challenge is to make large quantities of quality iron without blast furnaces or coke and use the nation's ample supply of domestic coals and iron ores. Process scale up Resultant iron nugget quality at pilot demonstration scale. Require new Ironmaking process that will utilize alternative fuels as they become available 	1. Develop a cokeless ironmaking technology that produces high-quality iron nuggets equivalent to pig iron produced in a blast furnace. Demonstrate energy-efficient production of high quality iron that is equivalent in quality to blast furnace pig iron and can be used directly by electric steelmaking processes (Q2-FY10). Steps include: <ul style="list-style-type: none"> Identify the most promising iron ore reduction processes to replace the coke-using blast furnace. The thermal and reducing capabilities of widely available coals such as bituminous and subbituminous can be harnessed to convert iron ore to iron metal with the heating taking place in furnaces of various types. Control process conditions such as reaction temperature and furnace atmosphere to optimize iron ore reduction. Provide a process step or other mechanism to separate impurities from the reduced iron ore. 	1. Reduce energy and carbon dioxide per unit of iron produced relative to blast furnace by 28% (from 18 MBtu/ton to 13 MBtu/ton of iron produced). <i>Total potential savings = 64 trillion Btu/year</i>



<p>Advanced Process Development</p> <p><u>Objective</u></p> <p>Improve process efficiency and dynamics. Results will include greater yield and less loss, such as the loss that occurs when scale is formed during reheating.</p>	<ul style="list-style-type: none"> • Pulverized coal is replacing an increasing percentage of coke in the blast furnace, the primary source of iron for integrated steelmaking. As coal use increases, blast furnace productivity and stability is altered. This effects the gas distribution in the blast furnace, altering the efficiency of the blast furnace. • Measuring a blast furnace's gas distribution is challenging, and is difficult to do. • A strong oxidizing environment exists in furnaces, even with low levels of oxygen, leading to the formation of slag. • Limitations to conventional furnace designs which do not exclude air (oxygen). • Excessive concentration of unburned gaseous fuels can create explosion hazard. 	<ol style="list-style-type: none"> 1. Use high-fidelity 3-D numerical simulation to optimize the distribution of solid materials charged into the blast furnace. Incorporate chemical kinetics and fluid flow into models to better predict blast furnace gas distribution, aiding in the optimization of solids distribution and overall blast furnace efficiency. Complete development of a computational fluid dynamics technique for optimizing burden in Q1-FY10. 2. Create completely safe, energy-efficient reheat system that significantly minimizes or eliminates scale formation during steel reheating (Q1-FY0). Provide reducing environment in vicinity of steel being reheated by creating a new burner type. Use furnace heat balance program to calculate heat demand in various reheat furnace zones. 	<ol style="list-style-type: none"> 1. Develop technique to guide optimizing the distribution of solids charged into the blast furnace, reducing energy use 5% (from 18 MBtu/ton to 17 MBtu/ton of iron). <i>Total potential savings = 1 trillion Btu/year</i> 2. Develop and demonstrate a scale-free reheat furnace at a pilot-scale level that reduces energy use by 27% (from 1.2 MBtu/ton to 0.325 million Btu/ton of steel). <i>Total potential savings = 6 trillion Btu/year</i>
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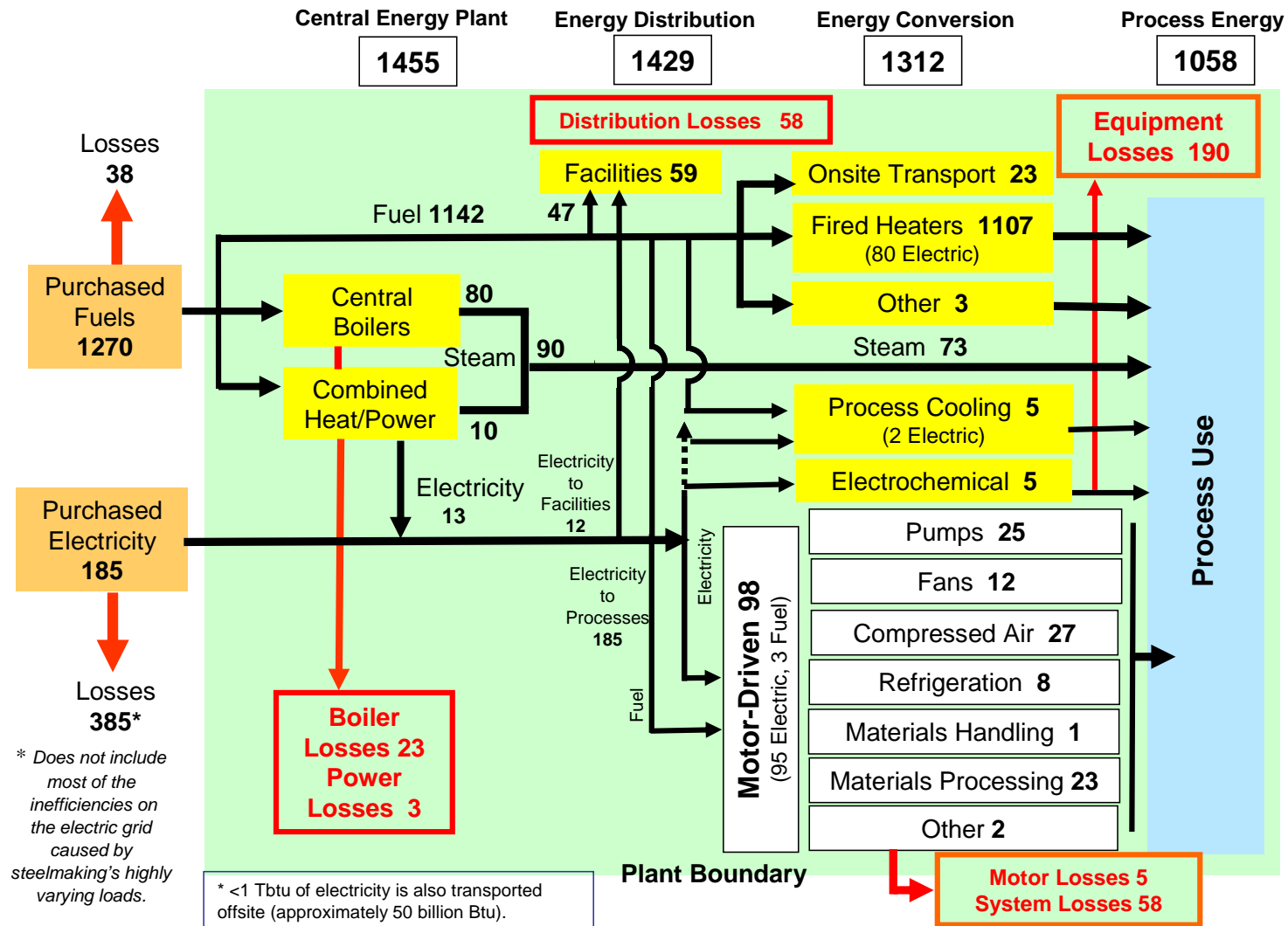
SOURCES:

- (1) Multiyear Program Plan, 5.4.1.7.6 Steel Bandwidth; and draft "Table 1. Energy Saving Opportunities for EAF Steelmaking (Liquid Steel and Reheating/Rolling)" and draft "Table 2. Energy Savings Opportunity for Ore Based Steelmaking (Hot Metal and Reheating/Rolling)." Drafts tables are based on footnotes 4 and 5 below.
- (2) *Steel Industry Technology Roadmap*, American Iron and Steel Institute, December 2001.
- (3) *Energy Use in the Steel Industry, A Historical Perspective and Future Opportunities*, John Stubbles, September 2000.
- (4) *Theoretical Minimum Energies to Produce Steel for Selected Conditions*, R.J. Fruehan, September 2000.
- (5) *Barriers and Pathways for Yield Improvement by Energetics*, Inc. October 7, 2003

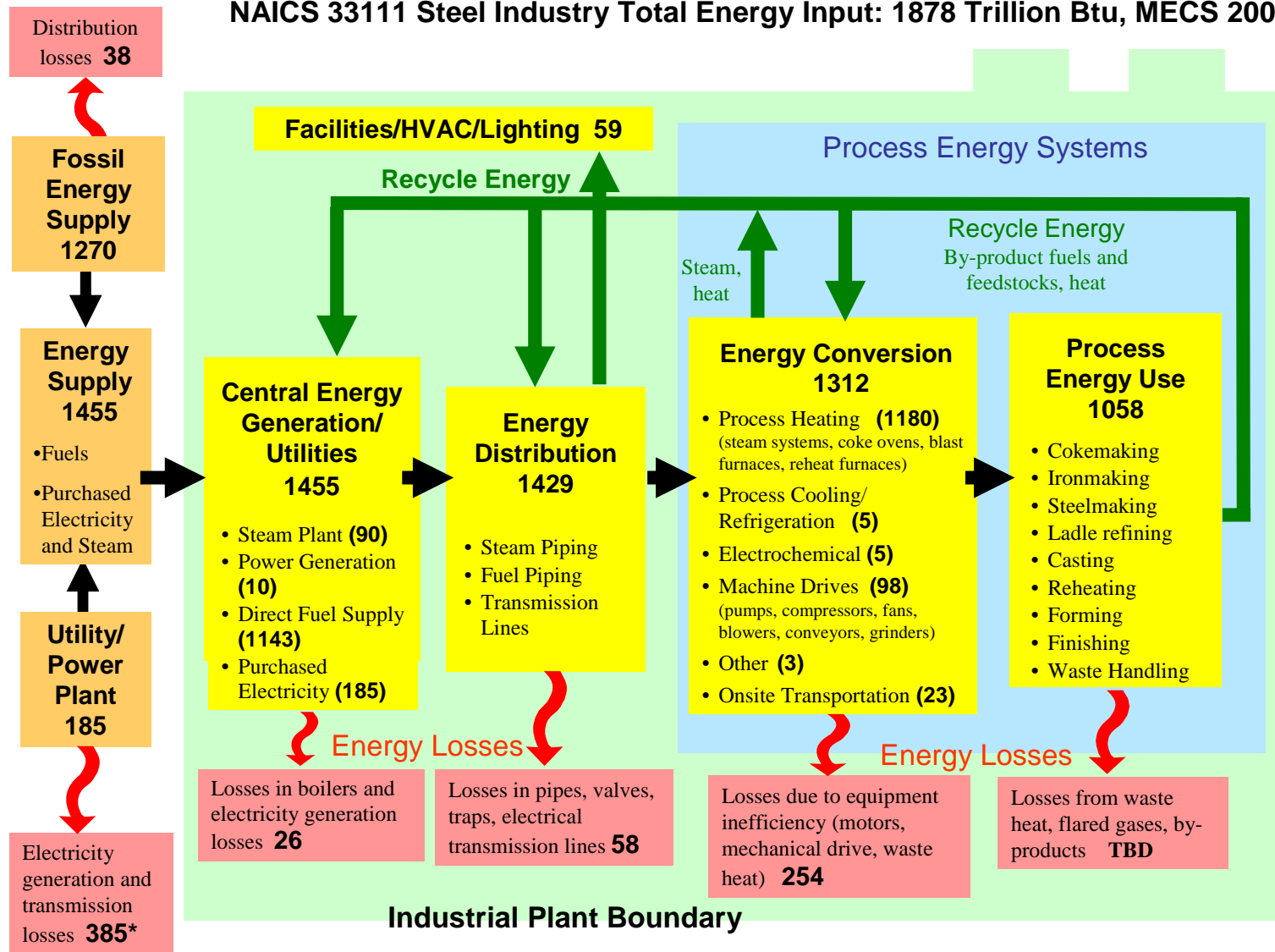


2.1.5.1 Steel Footprint

NAICS 33111 Steel Industry Total Energy Input: 1878 Trillion Btu, MECS 2002



NAICS 33111 Steel Industry Total Energy Input: 1878 Trillion Btu, MECS 2002



2.1.5.2

Typical R&D Needs from the Steel Industry Technology Roadmap

Ironmaking

Develop ability to use non-coking coals and low-value carbonaceous material

- Comprehensive model of the blast furnace, including fluid flow and kinetics
- Improved taphole clays and taphole/refractory systems
- Use of hot oxygen to increase coal injection rate

Better use of blast furnace off-gas and alternative fuels

Steelmaking

Basic Oxygen Furnace

- Robust process sensors for the BOF (bath carbon, temperature, slopping, waste gas composition, dusty bin levels, furnace shell temperatures, turndown elements)
- Models to optimize blast furnace and BOF operations
- Charge control model for better end-point control
- Integrated melter guidance system
- Scrap preheating techniques

Electric Arc Furnace

- Understanding of how preheating feed materials affects the process
- Understanding of how feed material size and shape affects melting time and yield
- Artificial intelligence techniques for EAFs
- Optimized operating cycles

Casting

- Ability to understand and actively control fluid flow, temperature, and chemistry
- Advanced heat transfer and fluid flow models
- Ability to monitor and actively control fluid flow, temperature, and chemistry (including wireless systems)
- Better understanding of the variation of heat transfer with casting conditions and alloy chemistry in strip casting

Rolling

- Characterization of thermodynamics and kinetics of phase transformations under stress
- Solidification modeling
- Hot surface defect detection and classification techniques



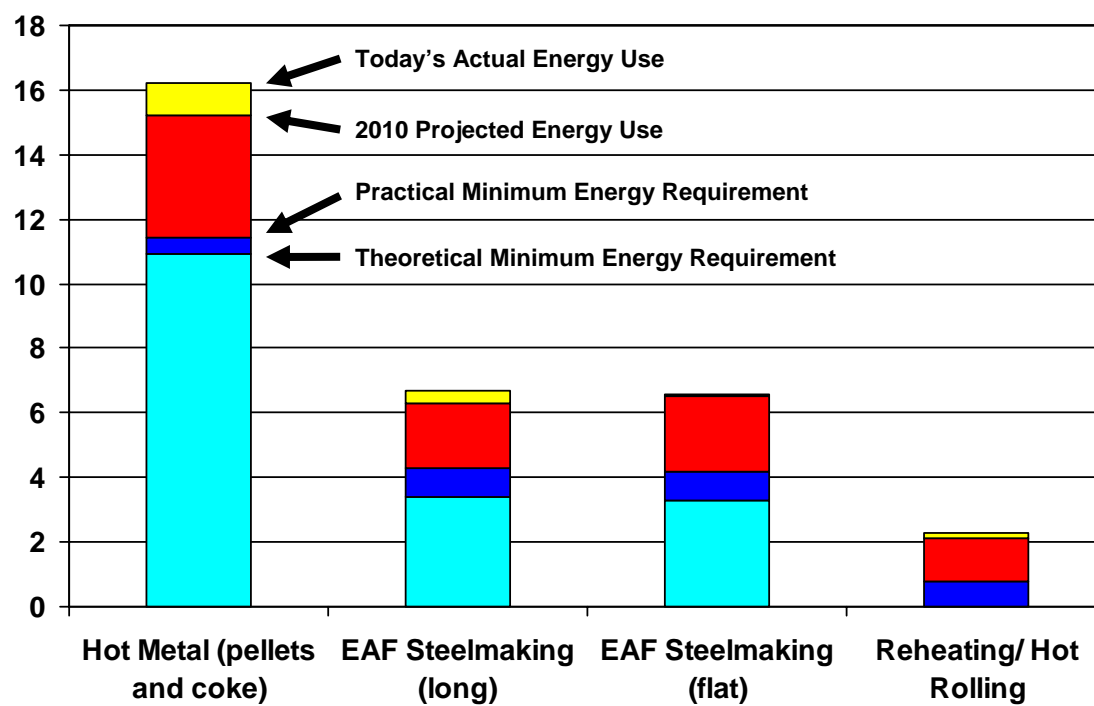
2.1.5.3

Steelmaking Energy Bandwidth and Program Goal (includes all operations though finished product)					
Steelmaking Route	I 2010 Projected MBtu/ton	II Liquid Steel Energy Savings MBtu/ton	III Hot Metal Energy Savings MBtu/ton	IV Reheating/Rolling Energy Savings MBtu/ton	V Program Goal ^a (I - II or III - IV) MBtu/ton
EAF long products	10.5	1.0	--	0.77	8.73
EAF flat products	10.3	1.125	--	0.60	8.575
Ore-based	20.0	--	3.05	0.65	16.3
Industry Weighted Average/shipped ton	15.0^c	--	--	--	12.3

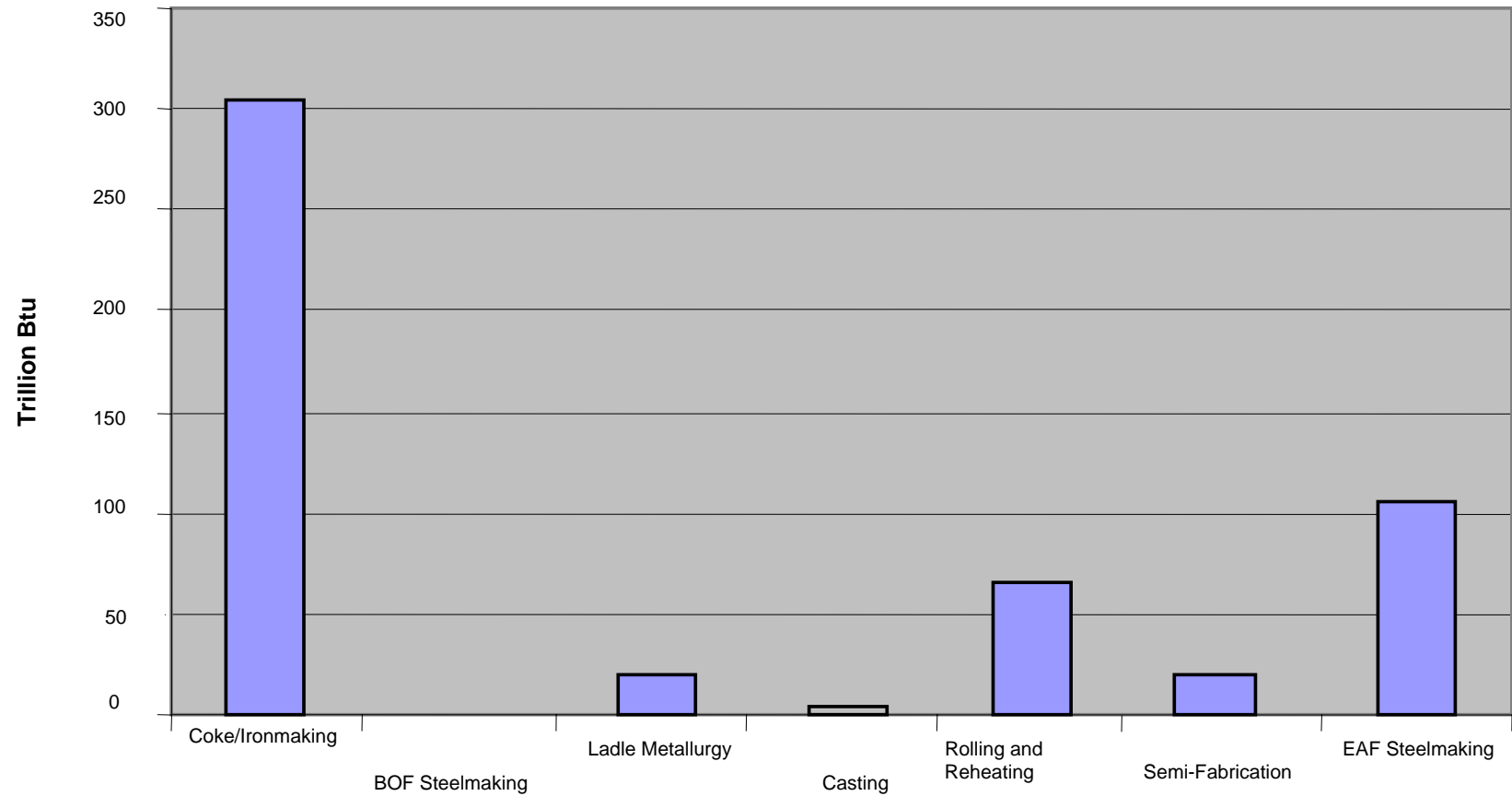


Steel Industry Energy Bandwidth

(10^6 Btu/ton)



Steel Energy Savings Potential “Bandwidth”



2.1.6 Information Technologies

Background

Information technology (IT) incorporates the design, development, implementation and management of computer-based information and communication systems. The IT industry deals with the use of equipment and software to convert, store, protect, process, transmit and retrieve information. It extends from chip production to the ultimate information user by way of transmission systems including the Internet and data centers. Certain elements of the information technology chain are known to be energy intensive. This sector has experienced phenomenal growth during this decade, as production capacity has more than doubled. Furthermore, according to EIA projections, shipments from the U.S. semiconductor industry will grow by 206% between 2005 and 2030, far above most other manufacturing industries.

Data centers are one major, fast growing IT energy user. Power demand for data centers, which require energy for both equipment operation and facility cooling, is growing at 12% annually. The data center industry estimates 5,000 enterprise class and mid-tier data centers will be in operation in the U.S. by 2011. And as computers and other devices become more powerful, they normally require greater amounts of energy to operate.

Virtually all the electrical power feeding data centers ultimately ends up as heat. The trend toward smaller and more powerful computing equipment and the use of “blade” servers has produced data centers crowded with hundreds or even thousands of racks of servers creating a huge concentration of heat that must be removed. The power and associated costs to cool the data center can be as much or more than the cost of powering the IT equipment (servers, storage, and networking). Indeed, one study suggested that 63% of a data center's electrical use is associated with cooling the IT equipment. Soaring demand for information technology, increasingly powerful microprocessors and the growing popularity of compact blade servers means that data centers are more densely packed than ever – and that means a tremendous demand for cooling.

Strategy

The initial ITP activity in Information Technology will be a study to identify the largest IT energy using sectors and highlight the least energy efficient IT sectors. Included will be “Internet generation” communications systems as well as classic wired and wireless telephony elements which can be significant energy users and/or incorporate energy inefficiencies.

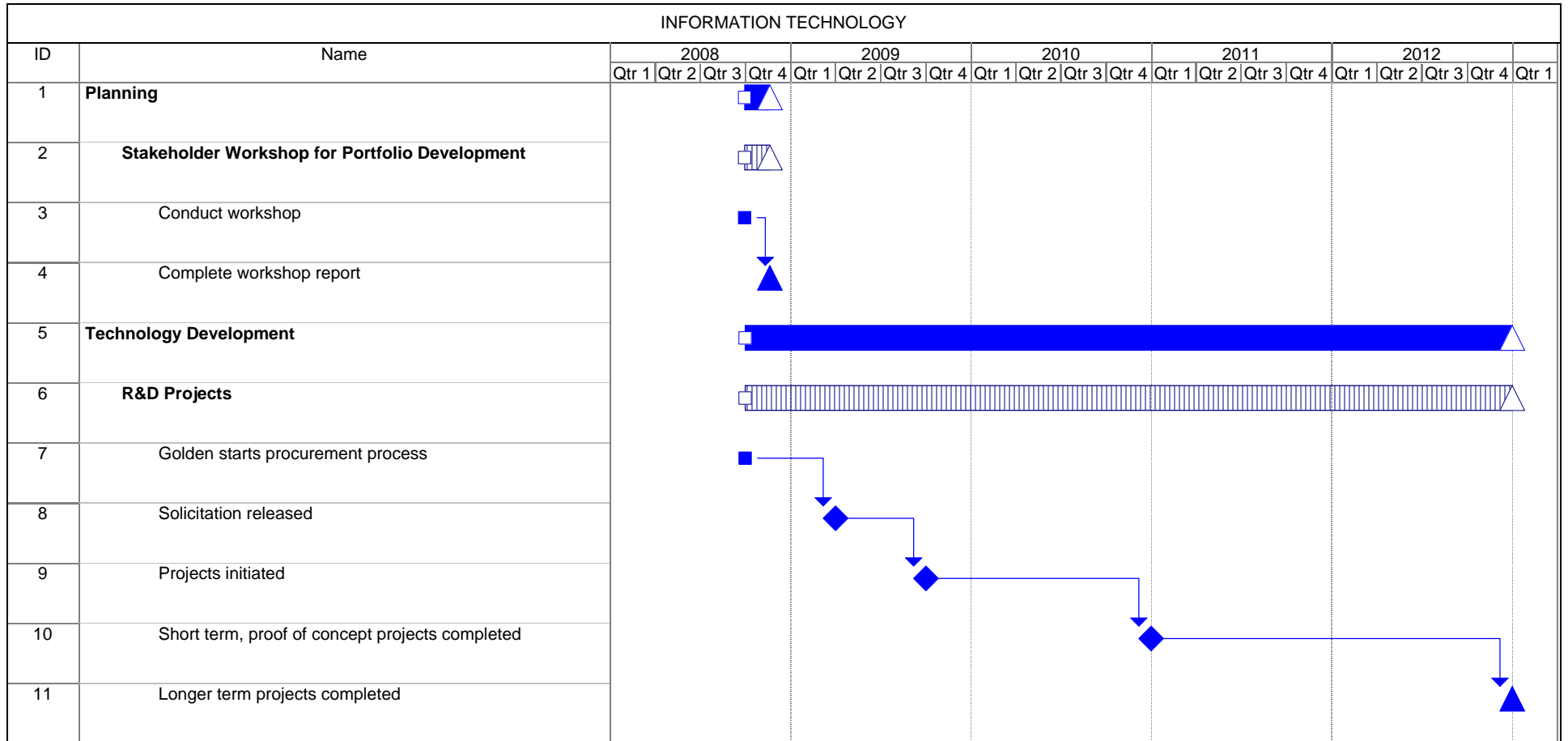
The next steps are to identify appropriate partners and conduct a workshop with these partners. Expected participants will be organizations that develop and use information technology, equipment and software, facility operators, national laboratories, educational institutions, other government agencies, industry associations and public interest groups with expertise in information technology. This stakeholder workshop will overall establish a government role in this area which is now supported by extensive industry sponsored research. The workshop will also identify IT technology needs which are compatible with ITP energy efficiency goals and capabilities, and will:

- Identify and address key, strategic drivers
- Establish a list of strategically driven needs
- Assemble the needs into multiple focus areas
- Pinpoint specific topics and roles for ITP action.

It is expected that the workshop will incorporate topics ranging from component manufacture to optimization of IT applications and investigate innovative hardware and software concepts to reduce energy use and heat generation in IT operations. Data centers are an excellent application of the strategy being developed here. Making the operation of data centers more efficient through hardware and software changes which reduce the energy used and thus, the heat generated has a double payback: the operation of the IT equipment of a data center is made more energy efficient (thereby generating less heat) and the quantity of energy needed for cooling is reduced.

ITP anticipates providing research funding for seed projects to investigate potentially fruitful approaches to reducing energy consumption and heat generation in data center components. Ultimately these redesigned components can be incorporated into a next generation data center. Furthermore, an additional activity which would provide an excellent integration of ITP R&D and BestPractices activities in IT would be a national data center testing and demonstration facility which could be used to verify the ability of new technologies to reduce data center energy consumption.

Last updated: 2/15/2008



Focus Area	Barriers	Pathways	Metrics
Enhanced Thermal Management in Data Centers	<ul style="list-style-type: none"> Data center industry purchases lowest initial cost equipment, not the most energy efficient. 	Demonstration to show reduced energy use and improved economics of reconfigured data centers incorporating semiconductor and ancillary improvements noted here.	Reconfigured data center which uses 25% less energy than latest generation and is economically attractive to this industry.
Ancillary Component Development	<ul style="list-style-type: none"> Initial component cost is dominant factor in purchase decision. Uninterruptible power supplies (UPS) consume considerable power and generate heat. Multiple stages of transforming AC power to low voltage DC generate considerable heat, illustrating the inefficiency of this conversion process. 	<p>Create high efficiency UPS; create low cost, high efficiency transformers.</p> <p>Make practical the separation of server components by placing transformers outside the building structure, away from the air conditioned area; run servers directly on low voltage DC piped throughout the data center building.</p>	Ancillary components which use 25% less energy and produce 25% less heat than current generation equipment.
Semiconductor Efficiency	<ul style="list-style-type: none"> Trend toward smaller, more powerful servers such as blade servers, has created a major concentration of heat that must be removed. 	<p>Identify and pursue new concepts to reduce server component electrical consumption.</p> <p>Demonstrate proof of concept; completely turn over to industry.</p>	A new generation of data center equipment which generates 50% less heat than current generation equipment.



2.1.7 Energy-Intensive Process R&D

Background

ITP has developed a new strategy, Energy-Intensive Process R&D (EIP), to address DOE's energy security strategic goal through improved industrial energy productivity and efficiency. The objective of the EIP is to focus ITP investments in several high impact, cross-cutting opportunities that provide the greatest energy savings and carbon reductions, while serving a broad industrial base. ITP is beginning this transition from predominantly industry-specific R&D to more crosscutting research in FY08.

Strategy

The core of the EIP strategy is the consolidation of R&D activities around four cross-cutting technology areas that could provide large energy benefits throughout the manufacturing supply chain, including industries identified by the National Association of Manufacturers such as the food & beverage, computer and electronic, and fabricated metal products industries. This technology-based strategy will allow ITP to maintain its historically close partnership with traditional end-user industries, while strengthening the participation and commitment of supplier and OEM industries to help develop and commercialize technology innovations.

There are several cross-cutting benefits of organizing around technology platforms, including:

- The ability to serve a wider range of U.S. industry and especially those that will continue U.S. global manufacturing leadership in energy and technology
- Sharpened focus on manufacturing technologies
- Maximum synergy among complementary technologies
- Greater flexibility in launching new initiatives
- More consistent, long-term R&D agenda versus discrete projects
- Easier to communicate with ITP stakeholders

Using the convening power of government to form working groups for future industrial cooperation, the Energy-Intensive Process R&D will focus on the following four platform areas:

- Industrial Reactions and Separations
- High Temperature Processes
- Waste Heat Minimization and Recovery
- Sustainable Manufacturing.

Last updated: 4/25/2008



2.1.7.1 Industrial Reactions and Separations

Background

Industrial reaction and separation processes transform raw materials (oil, natural gas, biomass, air, water, metals, and minerals) into energy, paper, chemicals and other products for use by utilities, manufacturing, and consumers. These key processes cross-cut several industries and are employed throughout the manufacturing chain. The petroleum refining industry uses chemical reactions and separations to turn crude oil into the gasoline and chemical feedstocks that keep the country running. The chemical industry uses reactions and separations to convert these feedstocks, natural gas, and other raw materials into basic inorganic and organic chemicals that are then further processed by the chemical and other manufacturing industries to produce finished goods. Chemical manufacturing alone produces more than 70,000 diverse products that are essential to the manufacturing sector. The paper making industry uses chemical reactions and separations to convert wood into energy and thousands of products that are essential for everyday needs in communication, education, packaging, and sanitation.

Opportunities abound to develop and implement advanced reaction and separation processes for the benefit of U.S. industrial competitiveness and energy security. Investments in reactions and separations can improve energy intensity in process industries, with separations being most critical in processes that involve water and require conventional distillation. Distillation alone accounts for about 15% of U.S. manufacturing energy use. Although improvements to individual installations won't necessarily offer enormous energy savings, cross-cutting improvements to separations aggregate to one of the largest opportunities for saving energy across multiple industrial sectors.

Key stakeholders include:

- Chemical and petrochemical industry
- Forest products industry
- Food processors
- Biorefineries, agri-processors, bioenergy industry.

Strategy

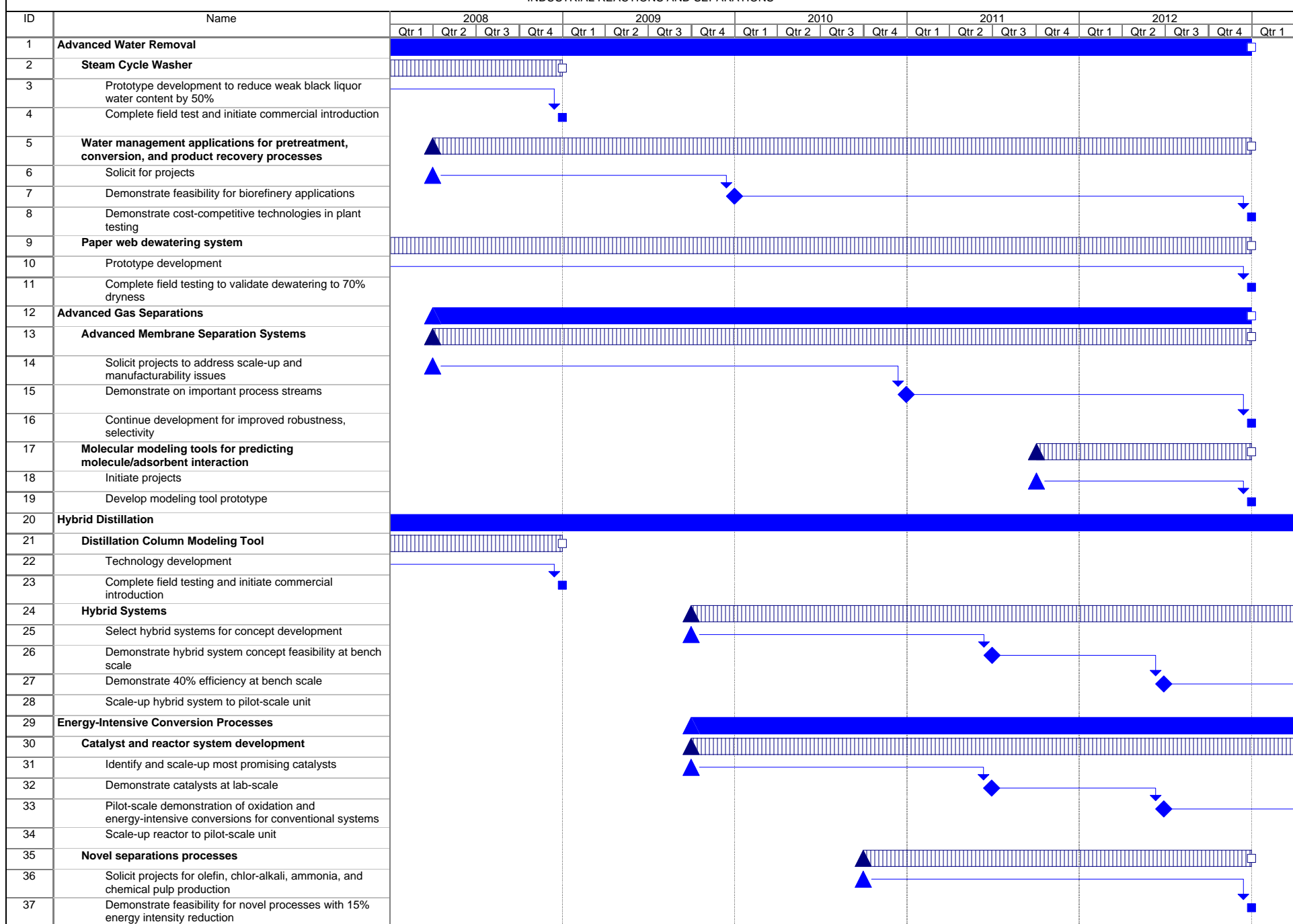
The industrial reactions and separations platform targets development and demonstration of advanced technologies for energy-intensive reactions and separations processes, focusing on accelerated development of cost-effective technologies for production of fuels, chemicals, and materials from renewable sources, which will increasingly form the basis for the 21st century economy.

The areas of technological focus for R&D investment under this platform include the following:

- Advanced Water Removal
- Advanced Gas Separations
- Hybrid Distillation
- Energy-Intensive Conversion Processes.



INDUSTRIAL REACTIONS AND SEPARATIONS



Industrial Reactions and Separations			
Focus Area	Barriers	Pathways	Metrics
Advanced Water Removal <u>Objective</u> Develop non-thermal water removal technologies that will reduce the energy requirements for water removal in high-volume process industries and emerging biorefineries	<ul style="list-style-type: none"> Uncertainties in applying new processes to different types of paper grades and biomass Regulatory (environmental) concerns for new technology implementation Technology acceptance in mature industries with sunk capital costs Economic attractiveness of efficiently recovering dilute products 	<ul style="list-style-type: none"> Develop non-thermal water removal technologies that substantially reduce energy use in paper drying, black liquor concentration processes and other industrial processes. Develop improved water management technologies for the production of large volume fuels, chemicals, and materials from renewable feedstocks, thereby improving price competitiveness with petroleum feedstocks Develop water removal technologies for other large water-intensive applications, such as food processing 	<ol style="list-style-type: none"> Demonstrate non-evaporative technology that would reduce the energy by 20% per gallon of water removed without process or product degradation. <p><i>Total potential savings for this focus area estimated at 500 trillion Btu/year</i></p>
Advanced Gas Separations <u>Objective</u> Increase energy efficiency of membrane and adsorption technologies for gas separations by 30%, including oxygen/nitrogen separations, along with H ₂ , CO ₂ , and CO separations by simplifying gas production processes	<ul style="list-style-type: none"> Existing technologies for large-scale gas separation technologies result in gases that are not economically competitive in many applications Large capital investments already made for existing, established technologies 	<ul style="list-style-type: none"> Develop robust membrane separation systems that operate on real process streams, integrate effectively with other processes, can operate in harsh high-temperature environments, are easy-to-install, and have lower maintenance costs Investigate novel material concepts for dilute streams; develop scaleable, low-cost manufacturing techniques; identify step-change technologies that create surface areas; and develop simulation packages for membranes Develop adsorbents with high selectivity for complex mixtures; integrate materials research and process development; improve adsorbent forms and geometries; and demonstrate on important process streams Develop switchable adsorbents using non-thermal desorption technologies; improved high-performance conductors; non-conventional ways to desorb adsorbed molecules; process design tools for technology comparisons; non-conventional adsorbents (e.g., micelles, liquid crystals, enzymes, colloids); and molecular modeling tools 	<ol style="list-style-type: none"> Demonstrate robustness of advanced membrane separation systems on real streams; correlate data on adsorbents for high selectivity in complex mixtures (FY 2009) Demonstrate adsorption technology on key process streams (FY 2010) Demonstrate molecular modeling tools that predict interaction of molecules with adsorbents (FY 2012) <p><i>Total potential savings for this focus area estimated at 60 trillion Btu/year</i></p>



<p>Energy-Intensive Conversion Processes</p> <p><u>Objective</u> Develop new catalysts, reaction processes, and purification processes to improve yields of the most energy-intensive conversion processes, including oxidations</p>	<ul style="list-style-type: none"> Existing catalysts have limited selectivity, stability, and durability and are often expensive Limitations of homogenous gas-phase oxidation Limited applicability and acceptance of new processes and alternate feedstocks 	<ul style="list-style-type: none"> Develop new catalysts, reaction processes, and purification processes that improve catalyst selectivity and conversion during the production of ethylene oxide, terephthalic acid, and phenol Develop integrated catalyst, media, and reactor designs for new oxidation process Develop novel separation technologies that enhance product purification, solvent recovery, and dehydration 	<ol style="list-style-type: none"> Demonstrate 40% increase in reaction yields for conventional systems at pilot scale (FY 2012) Demonstrate 15% energy intensity reduction at the pilot scale, using new manufacturing processes for olefin, chlor-alkali, ammonia, and chemical pulp production (FY 2015) <p><i>Total potential savings for this focus area estimated at 200 trillion Btu/year</i></p>
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2.1.7.2 High Temperature Processing

Background

High temperature processing refers to the processing of raw materials and intermediate products at elevated temperatures in order to produce intermediate or finished products and alter the thermo-physical and chemical properties of the materials being heated, including both metals and non-metallic minerals.

Opportunities abound to develop and deploy improved technologies for processing raw materials and intermediate products (both metals and non-metals) at elevated temperatures that rely on the alteration of thermo-physical and chemical properties of materials to achieve product specifications in existing and emerging industries.

Key stakeholders include:

- Metal manufacturers
- Glass and ceramic manufacturers
- Metal casting industry
- Automotive industry.

Strategy

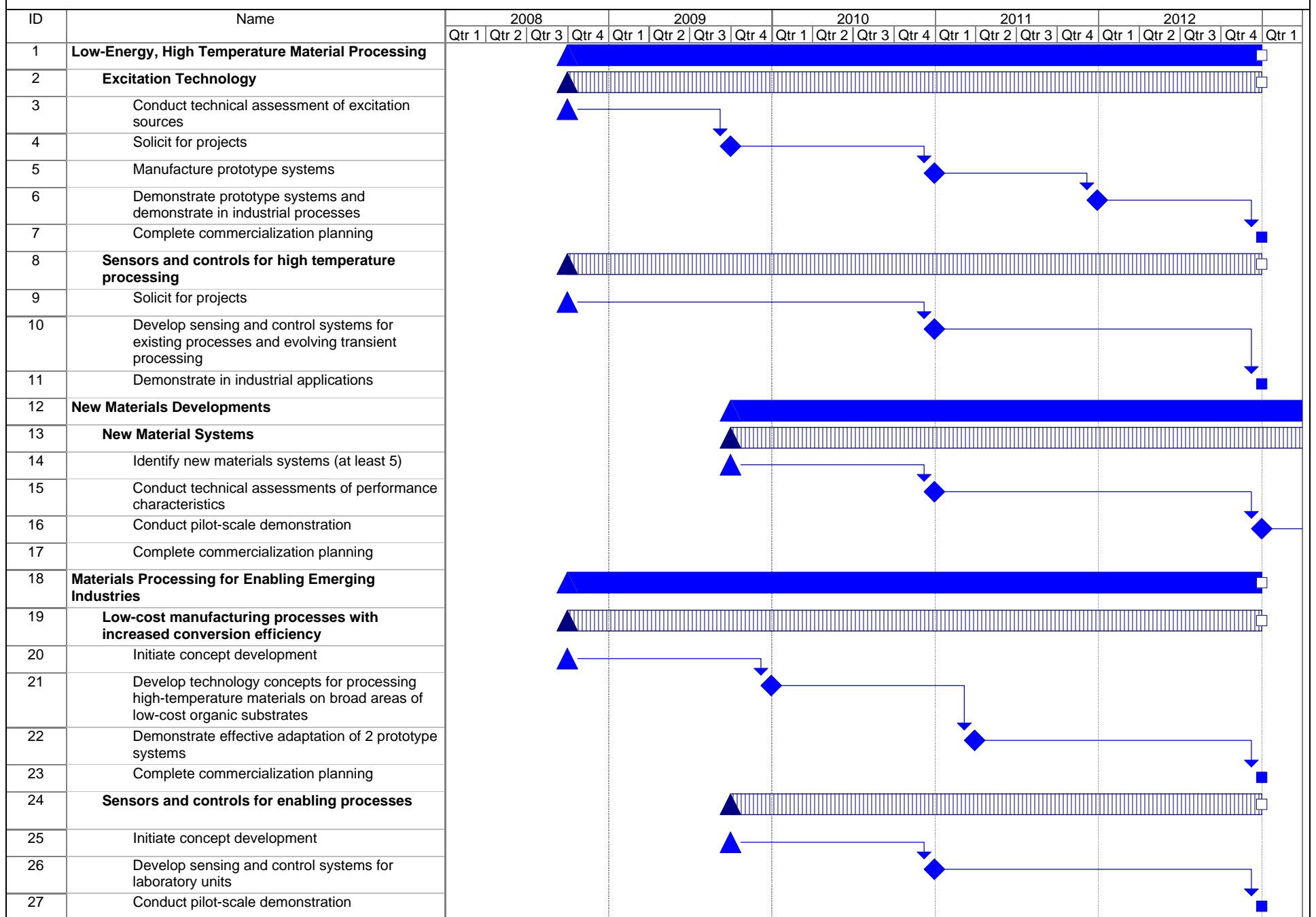
The overarching objectives of the cross-cutting high-temperature processing platform are to significantly increase the efficiencies of existing energy-intensive high-temperature processes; develop advanced materials and breakthrough technologies to significantly reduce energy intensity and greenhouse gas emissions; and develop new low-energy processes and products for emerging industries. Investments under this platform will reduce energy consumption by deploying lower-energy alternatives to conventional high-temperature processing technologies that currently account for nearly 50% of industrial energy usage today; and developing and implementing sophisticated transient thermal processing techniques to enable the manufacture of new energy devices that currently cannot be processed using conventional global high-temperature processes because of materials limitations.

The technology areas for R&D investment under this platform include:

- Low-Energy, High-Temperature Materials Processing
- New Materials Development
- Materials Processing for Enabling Emerging Industries.



HIGH-TEMPERATURE PROCESSING



High-Temperature Processing			
Focus Area	Barriers	Pathways	Metrics
Low-Energy, High-Temperature Material Processing <u>Objective</u> Reduce energy demands associated with conventional heat soak treatment cycles by developing high-power, yet low-energy transient thermal processes	<ul style="list-style-type: none"> • Lack sufficient understanding of the effects of thermal transients on final material properties • Existing processes frequently require long treatment cycles • Infrastructure changes and costs impede large-scale implementation of alternate technologies 	<ul style="list-style-type: none"> • Develop new low-energy, high-temperature transient processing methods, including those that shorten manufacturing cycles and those that could use alternative fuels in industrial processes • Develop advanced thermo-physical modeling techniques and integrated process monitoring and controls 	<ol style="list-style-type: none"> 1. Demonstrate feasibility for $\geq 20\%$ energy reduction using at least three new low-energy, high-temperature transient processing methods (FY 2010) 2. Manufacture prototype systems and successfully demonstrate their commercial viability in plant trials (FY 2012) <p><i>Total potential savings for this focus area estimated at 150 trillion Btu/year</i></p>
New Materials Developments <u>Objective</u> Enhance the performance of advanced steels, alloys, and other materials by modifying compositions and prescribed thermal mechanical processing	<ul style="list-style-type: none"> • Unproven reliability, safety, and cost-effectiveness of new materials • Environmental impact and operational costs of new material production and use 	<ul style="list-style-type: none"> • Develop key materials and alloys that enable enhanced and more efficient processes, while decreasing their environmental impact and operating costs • Develop new materials for additional applications, including transportation infrastructure, land vehicle systems, industrial reaction systems, power generation, and alternative energy areas 	<ol style="list-style-type: none"> 1. Demonstrate a minimum of 10% energy savings in at least three new materials systems in commercial manufacturing applications (FY 2013) 2. Achieve 20% energy savings from the demonstration of additional materials and expanded applications (FY 2015) <p><i>Total potential savings for this focus area estimated at 150 trillion Btu/year</i></p>
Materials Processing for Enabling Emerging Industries <u>Objective</u> Improve cost-competitiveness and performance of emerging alternative energy technologies that will enable the greater use of renewable energy in the U.S. in the next 15 years	<ul style="list-style-type: none"> • Difficulties controlling defects • Need to Reduce manufacturing costs and time • Inability to manufacture co-processed materials with vastly different melting points at a low cost • Need for large-scale deployment of new technologies 	<ul style="list-style-type: none"> • Develop non-vacuum-based processing methods suitable for photovoltaics and other emerging alternative energy technologies • Develop technology concepts, such as plasma lamp technology, for processing high-temperature materials on broad areas of low-cost organic substrates • Develop sensing and controls systems for the new technology concepts 	<ol style="list-style-type: none"> 1. Demonstrate non-vacuum-based process heating technologies that increases production rates with 30% conversion efficiency (FY 2012) 2. Demonstrate 30% cost reduction and increased energy efficiency for processing alternative energy technologies (FY 2015) <p><i>Total potential savings for this focus area estimated at 100 trillion Btu/year</i></p>



2.1.7.3 Waste Heat Minimization and Recovery

Background

Waste heat minimization and recovery consists of equipment and technologies used to convert, transport, manage, and recover or reuse energy needed for industrial processes. These systems include process heating and steam, which account for most of the energy used in processes in U.S. manufacturing sectors. Because of inefficiencies and unrecovered waste heat, there are large energy losses associated with process heating operations and steam generation.

Opportunities abound in waste heat minimization and recovery to improve yields per unit energy for multiple elements of the material manufacturing and process industries by improving overall energy efficiencies through the use of advanced combustion and heat recovery systems.

Key stakeholders include:

- Glass, aluminum, petrochemical, chemical, forest product industries
- Food processors
- Energy, steel, specialty metals, refining
- Process and manufacturing equipment producers
- Biorefineries
- Alternate energy sector.

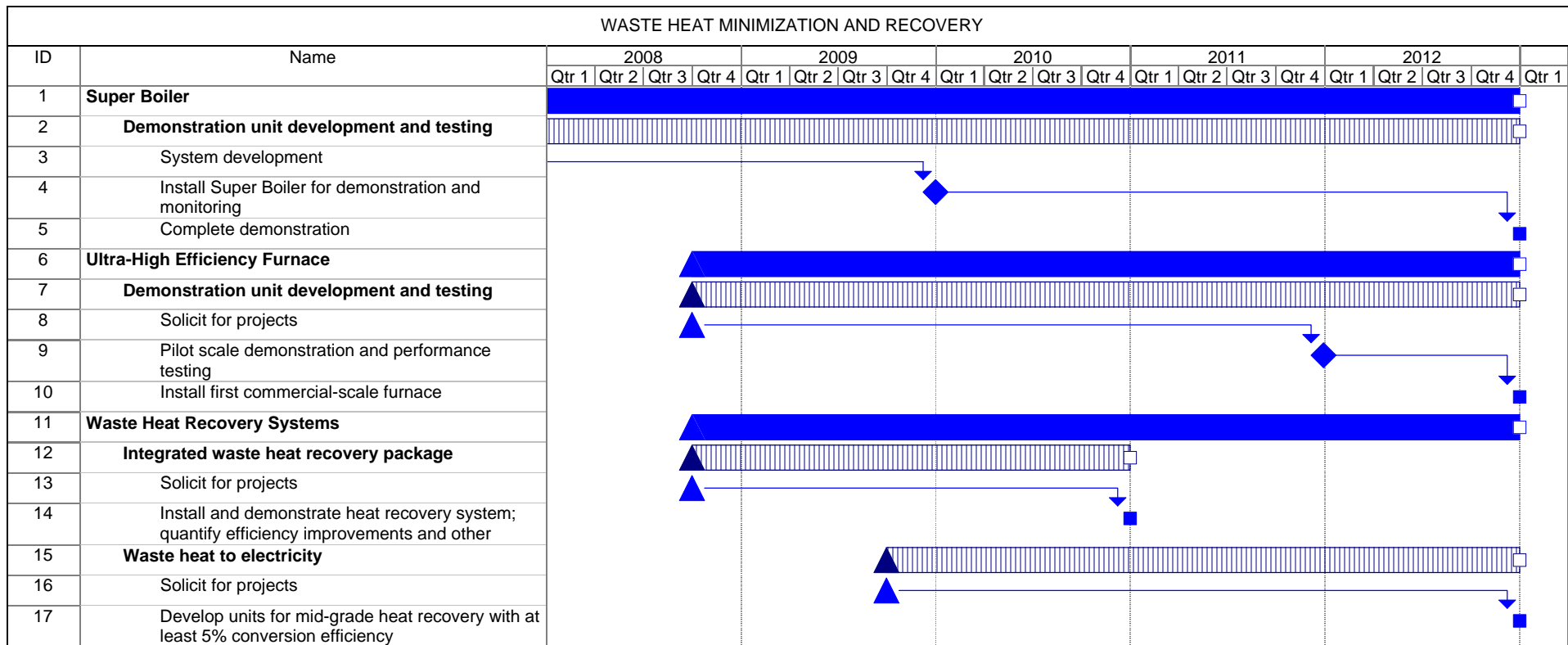
Strategy

Minimizing and recovering waste heat from industrial processes is one of the largest energy savings opportunities, and will significantly improve overall manufacturing energy efficiency. Improving the market for steam boilers and furnaces requires investment in waste heat minimization technologies and advancing the deployment of relatively underused opportunities to reduce fuel demands using waste heat recovery. This includes concentrating on advanced heat transfer and energy conversion materials, coatings, systems, and testing; advanced heat transfer technologies; reduced fouling technologies; component- and system-level computational modeling and simulation; and advanced system validation.

The technology areas for R&D investment under this platform include the following:

- Super Boiler
- Ultra-High Efficiency Furnace
- Waste Heat Recovery Systems.





Waste Heat Minimization and Recovery			
Focus Area	Barriers	Pathways	Metrics
Super Boiler <u>Objective</u> Develop technologies to produce steam with high efficiency, reliability, and lower costs; Super Boilers will generate steam with 25% greater efficiency and a smaller footprint than currently installed boilers	<ul style="list-style-type: none"> • Difficulty in achieving emissions reductions while increasing operational efficiency • Difficulty in expanding low emission designs to multi-fuel firing capability • Boilers are frequently rebuilt beyond their designed lifetimes instead of being replaced by new units 	<ul style="list-style-type: none"> • Develop a boiler combining a suite of advanced technologies into a cost-effective, integrated package that includes stage-intercooled combustion with internal recirculation, micro-channel heat transfer, flue gas heat/water recovery, and smart control systems (first-generation) • Extend ultra-low emissions design from firetube boiler configurations to watertube configurations and advance multi-fuel firing capability (second-generation) 	<ol style="list-style-type: none"> 1. Demonstrate second-generation Super Boiler with similar system performance in a commercial installation and capable of utilizing a fuel other than natural gas (FY 2010) <p><i>Total potential savings = 230 trillion Btu/year</i></p>
Ultra-High Efficiency Furnace <u>Objective</u> Develop improved furnace technologies initially targeted for advanced aluminum and steel furnace applications	<ul style="list-style-type: none"> • Difficulty in developing new concepts without adding to process complexity • High capital costs; furnace designs need to be cost-effective to operate and demonstrate acceptable capital recovery • Risk associated with system reliability for novel technologies 	<ul style="list-style-type: none"> • Develop ultra-efficient melting concepts with lower costs and reduced furnace size • Develop integrated furnace system incorporating advanced materials and sensors and controls to optimize performance 	<ol style="list-style-type: none"> 1. Demonstrate ability of prototype system to achieve >10% increase in furnace efficiency (FY 2010) 2. Demonstrate advanced furnace system in commercial aluminum or steel plant (FY 2012) <p><i>Total potential savings for this focus area estimated at 90 trillion Btu/year</i></p>
Waste Heat Recovery Systems <u>Objective</u> Develop and demonstrate cost-competitive technologies that recover and utilize waste heat from industrial applications	<ul style="list-style-type: none"> • Waste heat recovery can increase process complexity • Heat-exchange equipment encounters significant fouling and corrosive gases • Risk associated with recovery system reliability for novel technologies • High current cost of recovering waste heat to produce electricity 	<ul style="list-style-type: none"> • Develop a cost-effective, integrated waste heat recovery package combining a suite of advanced technologies that can be deployed in multiple industry applications • Develop compact, light-weight, cost-effective materials, components, and systems to convert waste heat to high-value electricity at least one order of magnitude lower than benchmark technology 	<ol style="list-style-type: none"> 1. Demonstrate advanced, integrated waste heat recovery package in an industrial plant (FY 2010) 2. Demonstrate a low-temp (~150°C) heat-to-electricity unit that produces 100-W at 5% conversion efficiency in forest products, chemical, and petroleum refining industry applications (FY 2013) 3. Demonstrate a high-temperature (>700°C) heat-to-electricity unit that produces 100-W electricity at 12-14% conversion efficiency in glass and aluminum industry applications (FY 2015) <p><i>Total potential savings for this focus area estimated at 260 trillion Btu/year</i></p>



2.1.7.4 Sustainable Manufacturing

Background

Sustainable manufacturing supports the entire spectrum of manufacturing industries, enabling increased productivity and efficiency in a variety of core industrial processes. Investments in sustainable manufacturing will improve energy efficiency by developing and deploying technologies that enable the manufacture of components that have multiple market applications; and coupling various design options, materials combinations, and manufacturing technologies to reduce process steps or parts count to remove energy intensity from the supply chain at the systems level.

Key stakeholders include:

- Metal-forming/cutting and heat-treating industries
- Metals processing, forming, and component suppliers
- Transportation manufacturing
- Fabricated consumer product industry
- Process and manufacturing equipment producers
- Mining, chemical, petroleum, agriculture, pulp and paper.

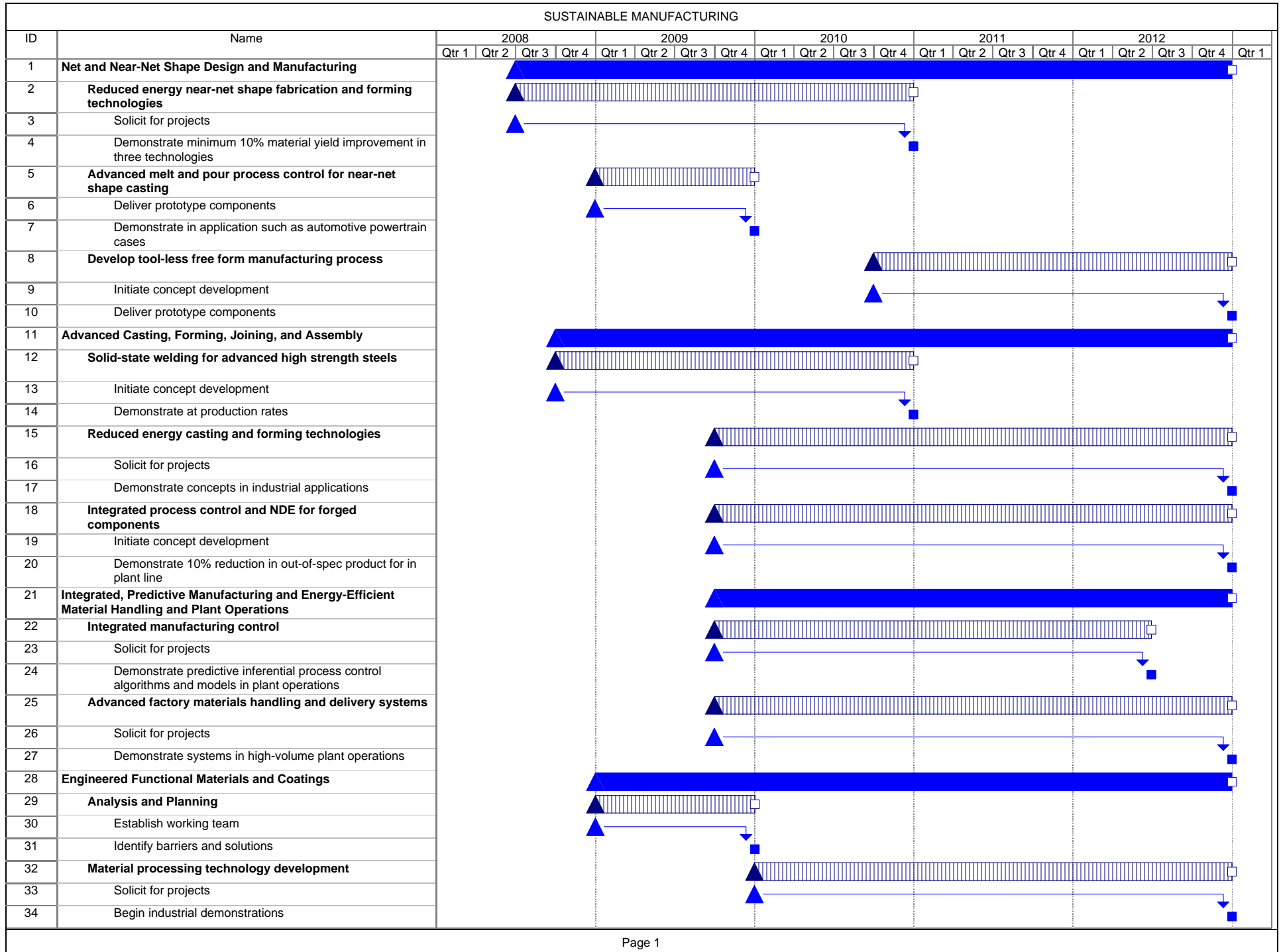
Strategy

The sustainable manufacturing platform will improve yields per unit energy cost for multiple elements of the manufacturing supply chain and reduce waste and/or improve energy efficiency, while demonstrating air- and water-neutral production methodologies. Sustainable manufacturing focus areas are aligned with the need to address the efficient use of energy and sustainable energy resources in the processing of energy-intensive materials and components; the desire to increase the use of sustainable, renewable, and recyclable materials in the manufacture of energy-intensive products; and the identification of technology opportunities that exist with the global integration of intelligent design, process control, fabrication and assembly, and real-time product control.

The technology areas for R&D investment under this platform include the following:

- Net and Near-Net Design and Manufacturing
- Engineered Functional Materials and Coatings
- Advanced Casting, Forming, Joining, and Assembly
- Integrated, Predictive Manufacturing and Energy-Efficient Material Handling and Plant Operations.





Sustainable Manufacturing			
Focus Area	Barriers	Pathways	Metrics
Net and Near-Net Design and Manufacturing <u>Objective</u> Enable the development of highly-capable net and near-net shape forming and manufacturing technologies deployed within highly integrated design, process control, and intelligent manufacturing operations	<ul style="list-style-type: none"> Existing free form fabrication for tool-less near-net shape forming has not achieved expected energy efficiency, material sustainability, and cost goals Net and near-net shape manufacturing technologies lack intelligent tools and controls required to maintain competitiveness Incomplete knowledge of relationship between materials properties and performance 	<ul style="list-style-type: none"> Develop reduced energy net and near-net shape metal fabrication and forming technologies that integrate design, process control, and real-time product properties Integrate advanced melt and pour process control for near-net shape castings for applications such as automotive powertrain cases Develop tool-less free form manufacture process for net-shape aluminum components for applications such as automotive chassis 	<ol style="list-style-type: none"> Demonstrate a minimum of 10% material yield improvement for at least three reduced-energy net and near-net shape metal fabrication and forming technologies (FY 2010) Demonstrate and validate >20% energy input reduction for selected metal forming and manufacturing operations with integrated efficient material handling systems (FY 2015) <p><i>Total potential savings for this focus area estimated at 140 trillion Btu/year</i></p>



<p>Advanced Casting, Forming, Joining, and Assembly</p> <p><u>Objective</u> Integrate design, process control, and intelligent manufacturing into casting, forming, joining, and assembly operations for increased energy efficiency and industrial competitiveness</p>	<ul style="list-style-type: none"> • Successful deployment of energy efficient, high-yield materials depends on technologies that fully integrate design, development, and real-time control in a sustainable environment • Lack of robust integration techniques for employing intelligent manufacturing tools and controls to achieve efficient casting, forming, joining, and assembly • Joining and assembly must be accomplished without compromising dimensional and structural integrity 	<ul style="list-style-type: none"> • Develop reduced-energy casting and forming technologies that integrate design, process control, and real-time product properties and performance monitoring that result in 10% material improvement • Develop cold forming and solid-state joining of aluminum structural components for applications such as vehicle bodies • Demonstrate manufacturing integration of efficient material handling and industrial plant operations to validate 20% energy input reduction for selected metal forming and manufacturing operations 	<ol style="list-style-type: none"> 1. Demonstrate >15% energy savings for solid-state welding for Advanced High Strength Steels (AHSS) at production rates (FY 2010) 2. Demonstrate an integrated process control and non-destructive materials characterization method that achieves a 10% reduction in out-of-spec products in a finished aluminum forged component line or similar application (FY 2012) 3. Demonstrate integrated forming, solid-state forming, and high-speed machining with intelligent process control and product characterization to achieve at least a 10% increase in material and/or product yield and 10% energy input reduction (FY 2015) <p><i>Total potential savings for this focus area estimated at 75 trillion Btu/year</i></p>
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<p>Integrated Predictive Manufacturing and Energy-Efficient Materials Handling and Plant Operations</p> <p><u>Objective</u> Integrate predictive and intelligent design, material processing, physical and mechanical property sensing, and real-time process control and feedback into a sustainable manufacturing environment by focusing on the elimination of lost product, end-product optimization, energy efficient material handling and transport, and sustainable plant operations</p>	<ul style="list-style-type: none"> • Lack robust predictive process and manufacturing control systems, integrated materials handling and management strategies, and real-time quality control systems needed to eliminate material and product waste • Manufacturers have been slow in adopting integrated intelligent manufacturing tools and controls for efficient and sustainable materials handling and plant operations 	<ul style="list-style-type: none"> • Develop predictive inferential process control algorithms for key applications, such as multi-process metal forming operations • Develop and demonstrate integrative non-destructive and real-time product and process control tools to reduce material and product rejections • Develop real-time predictive control tools for energy-efficient materials processing and handling to reduce energy in high-volume operations, such as automotive vehicle paint lines 	<ol style="list-style-type: none"> 1. Demonstrate in-factory energy control and material recovery/abatement processes to reduce energy and waste materials by 20% for an automotive paint line serving 200,000 vehicles (FY 2013) 2. Demonstrate integrated non-destructive and real-time product and process control tools to reduce manufacturing material and product rejection rates by over 15% (FY 2013) 3. Demonstrate integration and intelligent control of multiple non-destructive evaluation, physical, and mechanical characterization tools, and advanced vision systems for complex multi-material fabricated structures (FY 2015) <p><i>Total potential savings for this focus area estimated at 130 trillion Btu/year</i></p>
<p>Engineered Functional Materials and Coatings</p> <p><u>Objective</u> Develop and deploy materials and coating technologies to enhance energy efficiency, reduce environmental impact, and improve sustainability of manufacturing processes; replace energy-intensive processes; or improve the energy efficiency of end-products</p>	<ul style="list-style-type: none"> • Product performance requirements are constantly evolving and driving demand for advanced functional materials and surfaces, along with low-cost, energy-efficient manufacturing processes • Difficulties integrating sustainable manufacturing processes into existing plant infrastructure and operations • Difficulties integrating non-homogenous materials into a functional component/process 	<ul style="list-style-type: none"> • Develop near- and long-term thermal, mechanical, chemical, and electrical performance targets for high energy-consuming manufacturing process equipment and products • Develop high-potential engineered functional material and coating technologies, such as: (1) ultra-hard, ultra-tough surfaces to improve reliability of forming and removal processes; (2) non-traditional surface processes to replace energy-intensive heat treatments • Integrate advanced engineered functional material and coating technologies into the manufacturing sector by: (1) developing material/surface treatment systems into manufacturing processes; (2) documenting energy and emissions metrics 	<ol style="list-style-type: none"> 1. Demonstrate manufacturing processes that reduce energy consumption by 25% by utilizing advanced materials and engineered surfaces (FY 2015) <p><i>Total potential savings for this focus area estimated at 100 trillion Btu/year</i></p>



2.1.8 Nanomanufacturing

Background

Nanomanufacturing is leading the next industrial revolution. Like historical developments of steam engines, electricity, and transistors, nanotechnology is a new frontier of science that is primed to completely disrupt a wide range of markets, industries, and business models worldwide. Similarly, it will provide our future manufacturing base with a new, radically precise, less expensive, and more flexible way of making products. Nanomanufacturing is the cost-competitive high-volume production of uniform nanomaterials and the integration of these nanomaterials into intermediate devices and finished products while retaining their unique properties at the nanoscale.

The U.S. government has invested \$8.3 billion in nanotechnology research over the past seven years, under the framework of the National Nanotechnology Initiative (NNI). However, the vast potential of nanotechnology cannot be fully realized without significant investment in applied research to translate scientific discoveries into new manufacturing processes and products.

By employing nanotechnology, industry can:

- Increase productivity through higher reaction rates and/or lower processing temperatures. Nano-catalysts will improve the efficiency and specificity of chemical reactions.
- Produce new and improved materials that provide superior life-cycle benefits. Nanoparticles can make metals lighter, stronger and harder, and can impart better formability and ductility properties to ceramics.
- Reduce friction in mechanical systems. High wear resistance coatings and the use of nanoscale lubricants will reduce the energy requirements of energy systems.
- Allow for revolutionary, cost-effective production capabilities.
- Allow for precise control of defect quantification and location, thereby reducing raw material volumes, byproducts, and wastes.

Key stakeholders include:

- Federal agencies in the National Nanotechnology Initiative, including NIST, NSF, DOE Office of Science, and DOD
- DOE National Laboratories
- Technical Societies (e.g., ASME, American Chemistry Council, etc.)
- Nanotechnology developers.

Strategy

Industrial participants at the *2007 Nanomanufacturing for Energy Efficiency Workshop* (Baltimore, MD) repetitively voiced their needs for: 1) high volume, reliable and consistent supply of nanomaterials, and 2) scalable unit operations to incorporate nanomaterials into products. Therefore, ITP will address these two major barriers that hinder the transition of nanoscience into industrial processes and products, by engaging:

- The development of innovative, pre-competitive process technologies for low-cost manufacturing of nanomaterials for a broad range of applications, including industrial processes, other energy technologies such as solar and fuel cell products, and general consumer products, and
- The development of technologies to enable the utilization of nanomaterials, either directly as a material (i.e., surface coated with nanocatalysts for much higher yield), or indirectly as an 'intermediate' device (i.e., nanosensors for thermal management), in energy-intensive industrial processes to improve overall efficiency.

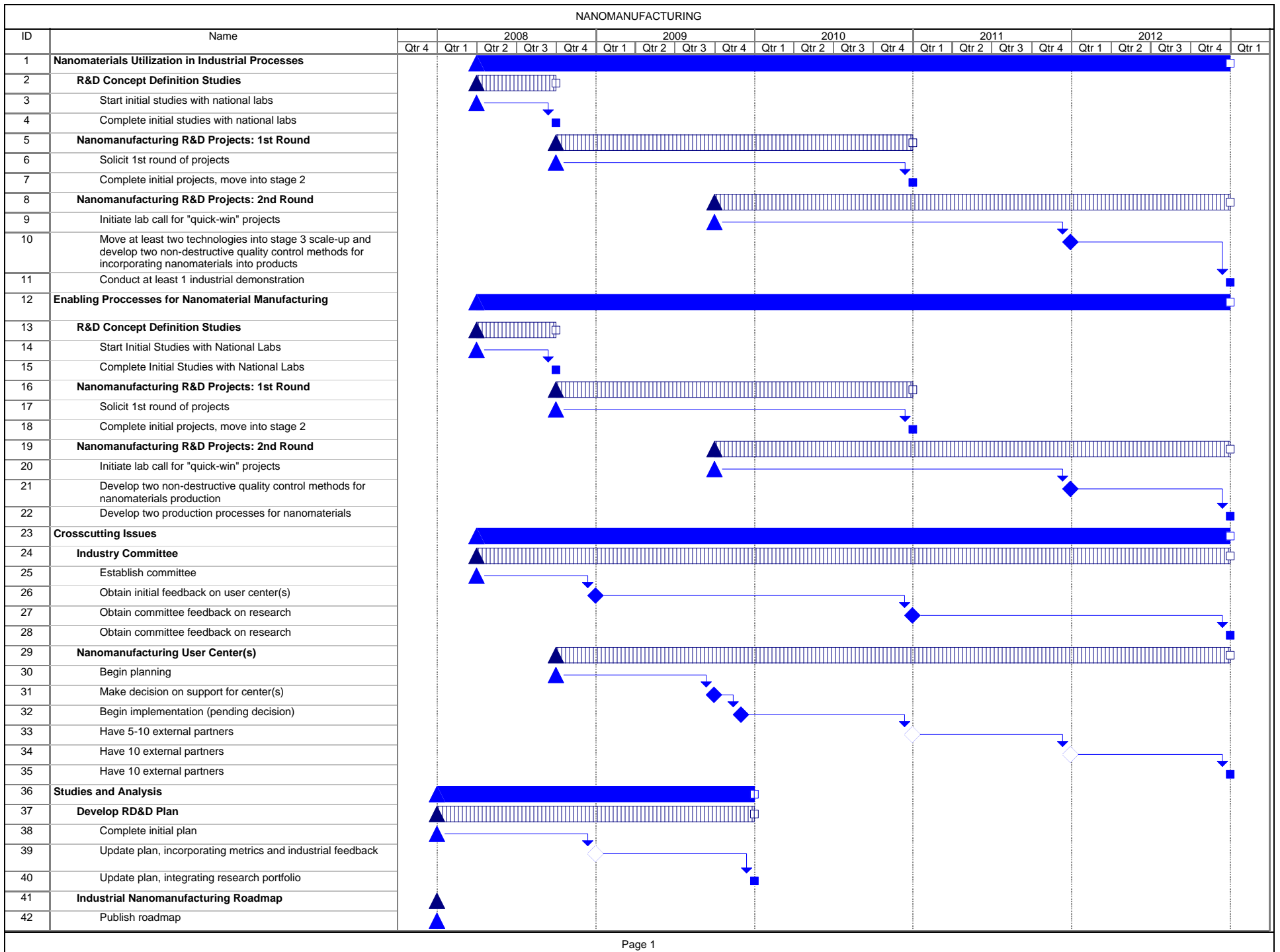
To be successful in these two areas, efforts will also be required in:

- Scaling-up laboratory fabrication methods techniques to low-cost, high-volume production, and integrating across scales: nanomaterials to nanointermediates to nano-enabled products, and
- Establishing and refining process and quality control techniques while manufacturing technologies are still evolving.

The ITP nanomanufacturing activity is also designed to be complementary to other programs of the NNI.

Last updated: 1/23/2008





Nanomanufacturing			
Focus Area	Barriers	Pathways	Metrics
Enabling Processes for Nanomaterials Production (Stage 2 R&D) <u>Objective</u> Improve reliability of nanomaterials supplies and scale up production processes	<ul style="list-style-type: none"> • Lack of reliability of nanomaterials supplies • Lack of technologies to improve materials properties and performance • Lack of ability to disperse stable nanomaterials through final production • Lack of processing capabilities for high temperature processes • Lack of process control methods for nanomanufacturing processes 	<ul style="list-style-type: none"> • Develop a series of economic scalable production systems that will produce uniform nanomaterials for a variety of markets • Develop robust, online characterization/monitoring tools for the production of nanomaterials to measure size, shape, and distribution for liquids and gas phases • Validate process scalability, product quality, and reproducibility 	<ol style="list-style-type: none"> 1. Two production processes for nanomaterials will be developed for commercial investments (stage 3/4) by FY12 2. Two non-destructive quality control methods for nanomaterials production will be developed by FY11
Nanomaterials Utilization in Industrial Processes (Stage 2 R&D) <u>Objective</u> Scale up manufacturing processes for utilization of nanomaterials in energy-related products	<ul style="list-style-type: none"> • Lack of scalable unit operations for reliable, cost-effective incorporation of nanomaterials into nanointermediates and products • Lack of ability to preserve the functionality of nanomaterials when incorporating them into nano-intermediates and products • Lack of characterization/monitoring tools for production processes that utilize nanomaterials • Lack of standard testing methods for quality of intermediates containing nanomaterials 	<ul style="list-style-type: none"> • Modify existing (non-nano) industrial processes to incorporate nanomaterials into liquids, films, polymers, patterning, sprays, ceramics, metals, etc. for industrial applications • Develop non-destructive quality control testing methods for processes that integrate nanomaterials into industrial "nano-enabled" products • Scale up nanomanufacturing and process monitoring/control processes. • Validate process scalability, product quality, and reproducibility • Make systems available to industry through user facilities 	<ol style="list-style-type: none"> 1. Two nanomanufacturing processes will be scaled up for commercial investments (stage 3/4) by FY11 2. Two non-destructive quality control methods will be developed for processes of incorporating nanomaterials into products by FY11 3. One nanomanufacturing user facility will be set up for commercial use by FY09



Supporting Activities	Description
<i>Studies & Analysis</i> <u>Objective</u> <i>Support R&D strategy decision making by analyzing energy savings and R&D investment opportunities to maximize the subprogram's impact.</i>	<ol style="list-style-type: none"> 1. Analysis of nanotechnology for energy applications: energy and economic impacts 2. Evaluation of options to convert nanoscale science R&D into applications R&D and commercialization 3. Evaluate options for industrial access to DOE funded nanomanufacturing capabilities to accelerate nanotechnology commercialization.
<i>Technology Delivery</i> <u>Objective</u> <i>Provide industry input to R&D strategy and promote commercialization of technologies.</i>	<ol style="list-style-type: none"> 1. Form industry stakeholder interface 2. Implement mechanisms for giving industry access to ITP-funded nanomanufacturing facilities and investigate incubation support for entrepreneurial commercialization partners.
<i>Cross-EERE Activities</i>	<ol style="list-style-type: none"> 1. Develop process to mine DOE-SC basic research projects and convert promising technologies into energy applications by technology innovation R&D 2. Develop interfaces with EERE programs performing enabling R&D to accelerate potential commercialization of nanotechnologies for energy efficient and renewable energy products



2.1.9 Industrial Distributed Energy

Background

Combined Heat and Power (CHP) is the sequential production and use of electricity and thermal energy from a single fuel. The widely recognized benefits of CHP include energy savings, cost savings, and reductions of CO₂ and other pollutants. CHP is a realistic, near-term option for large energy efficiency improvements and significant CO₂ reductions. While CHP is a well-established practice in large industrial processes with sizable electricity and thermal loads, *analyses indicate that there is still a largely untapped potential in applications less than 5 MW in electrical demand*. Increased deployment of CHP can help contribute to a 25% reduction in U.S. industrial energy intensity by 2017 and an 18% reduction in U.S. carbon intensity by 2012.

Industrial demand accounts for approximately one-third of U.S. energy and represents significant opportunities for energy savings. Relative to the separate generation of electricity and heat, CHP is one of the most effective commercially available alternatives for accomplishing sizable near-term energy savings and corresponding GHG reductions. A fully developed CHP market can lower energy consumption, offset imported oil, create job opportunities and improve the overall economic competitiveness of the United States.

All players in the energy industry are coping with fuel supply and price uncertainties, new and evolving federal and state energy policies, and the emerging need for new power infrastructure (generation, transmission and distribution). There are several key “big picture” drivers for energy utilization in industry:

- Projections for increased worldwide energy use
- Availability of fuels and feedstocks
- Energy price volatility
- Environmental regulation of CAP and GHG
- Fuel flexibility to enable renewable and domestic energy use

All of these factors contribute to the competitive positioning of CHP. The CHP community finds itself facing a unique window of opportunity where many forces are converging to drive a complete re-evaluation of how energy is traditionally supplied, delivered and used. Because of the capital-intensive nature of electricity supply and transmission, the consequences of the decisions that national and state officials will make on technical approaches, private-public sector partnerships, environmental cost-benefit tradeoffs, portfolio of supplies, and financing and cost-recovery are those that we will be living with for decades. The CHP and broader clean distributed energy (DE) community needs to present a clear vision of how the value of what we offer addresses national, state and local energy issues and how our proposed alternative should fit in the evolving energy model. Key stakeholders include the United States Clean Heat and Power Association (USCHPA), States, and Industries with intensive heating and cooling loads.

Strategy

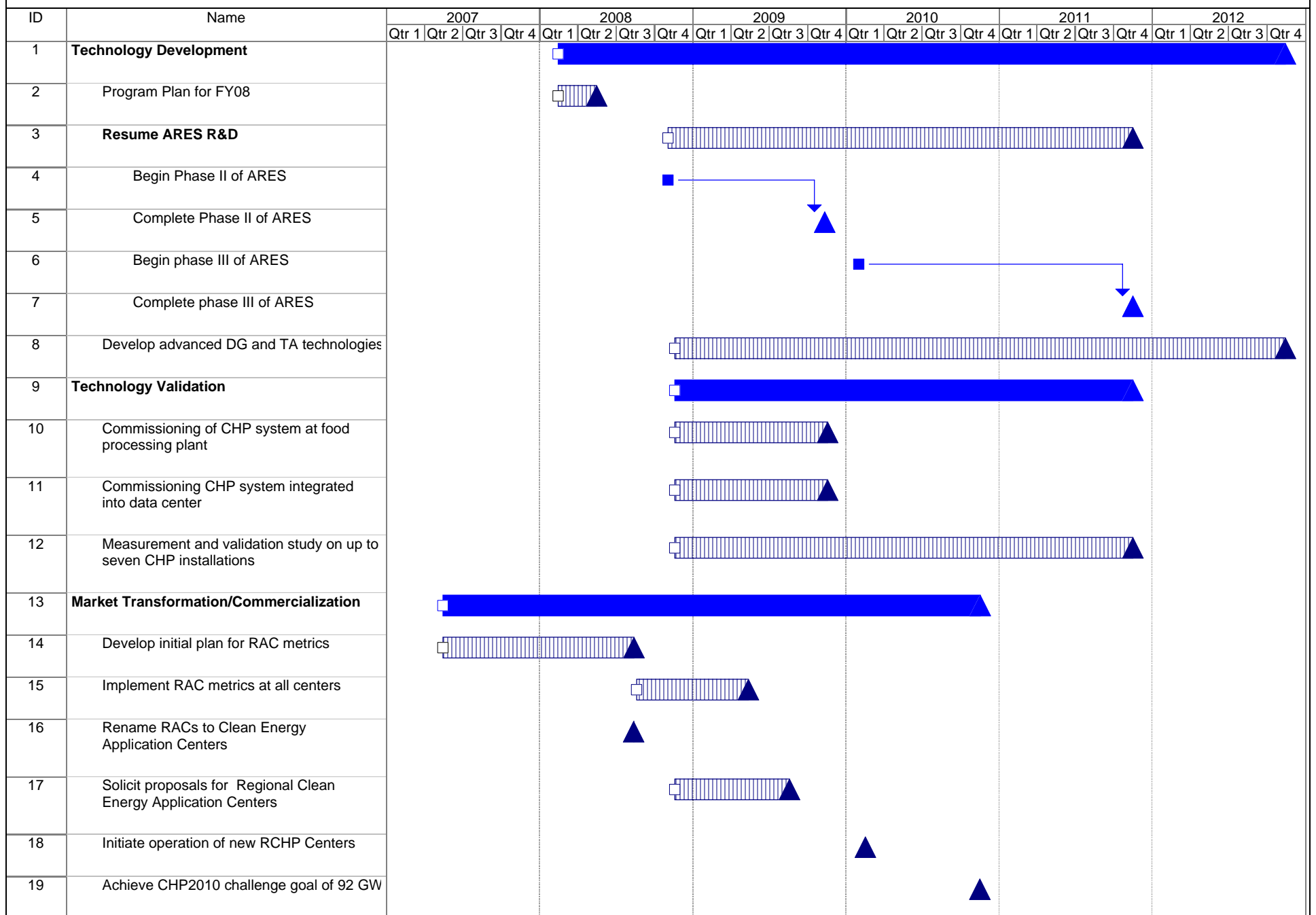
The programmatic approach developed recognizes the historic barriers to CHP market development, builds off of the success of predecessor DOE programs (DG/CHP Programs in Distributed Energy and Office of Electricity), leverages proven ITP technology delivery initiatives, and outlines a set of approaches and activities that done in partnership with key stakeholders will allow ITP to:

- Lead the deployment of technologies that will improve energy efficiency, reduce CO₂ emissions and improve industry competitiveness
- Address the barriers inhibiting CHP investment
- Serve as an independent voice of credibility on how to best deploy and apply CHP to optimize CO₂ reductions in industry
- Develop a strong coordinated communications plan to make to make CHP and industrial energy efficiency synonymous with industrial greenhouse gas reductions

ITP is undertaking a number of activities to spur widespread deployment of CHP in the United States. We are emphasizing innovative systems and applications that offer the greatest potential to reduce GHG through energy efficiency and displacement of fossil fuels by alternative fuels and waste energy streams. We provide technical expertise and catalyze consensus to resolve regulatory and institutional barriers that inhibit market development. The program also accelerates deployment of innovative CHP solutions by supporting demonstrations and technology performance validation projects done collaboratively with the private sector and other public sector entities. Partnering with private industry and states facilitates the transfer of innovation, information, tools, and services to a more local and regional level where key CHP regulatory policies are developed and where site-specific decisions on capital investment are made.

Last updated: 5/9/2008

INDUSTRIAL DISTRIBUTED ENERGY



Focus Area	Barriers	Pathways	Metrics
Technology Development	<ul style="list-style-type: none"> Emissions regulations keep getting tighter Economic return and “spark spread” inhibit equipment purchases Materials and operational capability issues with non-traditional [i.e. biomass/biogas] fuels Lack of equipment to capture low-grade waste heat Scalability of equipment 	<p>Develop clean, energy efficient distributed generation technologies that are capable of running on natural gas or renewable biomass/biogas fuels with no degradation of emissions profile, performance, or reliability, availability, maintainability or durability (RAMD). Technologies include:</p> <ul style="list-style-type: none"> Advanced Reciprocating Engines Systems Microturbines Turbines Fuel Cells <p>Technology development of thermal energy recovery technologies:</p> <ul style="list-style-type: none"> Desiccants Chillers Heat Exchangers <p>Development of integrated systems that capture and use waste energy streams to produce useful energy forms with minimal incremental fuel input.</p>	<p>Clean DG, TAT, and CHP systems that are economic, and meet or exceed environmental requirements.</p> <p>AREAS Phase 2: 47 % efficient, 0.1 gBHP NOx.</p> <p>ARES Phase 3: 50% efficient, 0.1 gBHP NOx.</p>
Technology Validation	<ul style="list-style-type: none"> Companies are reluctant to be the first to adopt new technologies Unproven technologies face financing obstacles Need scalability, transferability, and replicability 	<p>Cost-shared demonstrations projects in targeted sectors:</p> <ul style="list-style-type: none"> High energy intensity High energy consumption High growth [such as data centers] Non-traditional [such as food processing] High opportunity for replicability Have not fully implemented all energy efficiency opportunities 	<p>DG, TAT and CHP systems that are utilized and replicated across all industrial sectors.</p> <p>Demonstrate a CHP system at a food processing plant.</p> <p>Demonstrate a CHP system at a data center facility.</p>
Market Transformation/ Commercialization	<ul style="list-style-type: none"> Utility resistance Regulatory Issues Financing Risk Knowledge Gap of Value Proposition 	<ul style="list-style-type: none"> Partnerships in priority sectors and states Communications and outreach campaign Analysis Technical outreach/best practices Education and Training Regional Application Center assistance 	<p>CHP systems are considered and evaluated in all energy efficiency projects.</p>



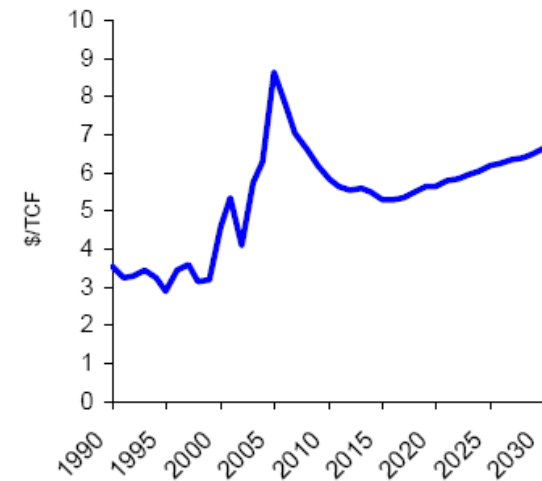
2.1.10 Fuel and Feedstock Flexibility

Background

U.S. industry, the largest user of energy domestically, is principally dependent on natural gas as a single major source of fuel or feedstock. After decades during which natural gas for industrial use traded at or below \$3.50/thousand cubic feet (TCF), the turn of the millennium marked the beginning of unprecedented increases and volatility in natural gas prices. Increased use of the fuel across the economy coupled with diminishing domestic natural gas supply and production appear to have driven a fundamental shift in natural gas price behavior. In fact, Department of Energy (DOE) Energy Information Agency (EIA) projections indicate that the price of natural gas over the next 20 years will likely be more than double those of the past (see graphic below). In this environment, many industrial users whose competitiveness is predicated on inexpensive natural gas must seek alternatives for their energy requirements.

Alternative fuel use presents a sizeable opportunity for reducing natural gas use, particularly with the escalation in natural gas and petroleum prices since 2004. ITP is initiating a fuel flexibility program to accelerate the market adoption of emerging technology options for industry, such as the utilization of gasified fuels, landfill gas, and electrotechnologies. In March 2007, DOE completed an assessment* of whether flexible, alternative fuel use in industry presents a sizeable opportunity for the reduction in consumption of natural gas. In that assessment, opportunities and constraints were developed in light of three main areas:

- ▶ Alternatives to natural gas and their displacement potential: Addresses the maturity of technical solutions, the readiness and availability of alternative fuels/resources, the costs and risks required to adopt fuel flexibility options, the potential displacement amounts within individual industrial sectors, and short-term and long-term goals.
- ▶ Industry interest in the initiative: Addresses industrial actions underway to adopt fuel flexible solutions, industrial views on constraints (e.g., regulatory, technical), and industry's ability to overcome these constraints.
- ▶ Appropriate government (specifically DOE) role: Addresses gaps between actions industry has already taken and the identified constraints, constraints best addressed by the federal government, and targeted actions DOE can take to optimize the impact of industrial fuel flexibility and achieve displacement goals.



Source: EIA AEO 2007

The analysis determined there are significant opportunities for fuel and feedstock flexibility, and suggested a set of activities DOE could undertake to accelerate a program for industry. (The *Opportunities and Constraints* report listed some 30 potential actions matched to the specific constraints identified by industry. These form the basis of this program plan.)

Strategy

DOE's early work to evaluate the initial scope and possible outcomes for such a program has shown the need for research and demonstrations as well as targeted investigations, to prove the viability of fuel and feedstock flexibility options to a wide industrial audience. In broad terms, the program, which will be initiated in FY08, needs to be cross-cutting and provide insights into various methods to reduce the industrial consumption of natural gas. More importantly, the program needs to catalyze actions so that results are highlighted early and drive additional projects undertaken by industry. To that end, the program is designed to undertake actions in three broad categories:

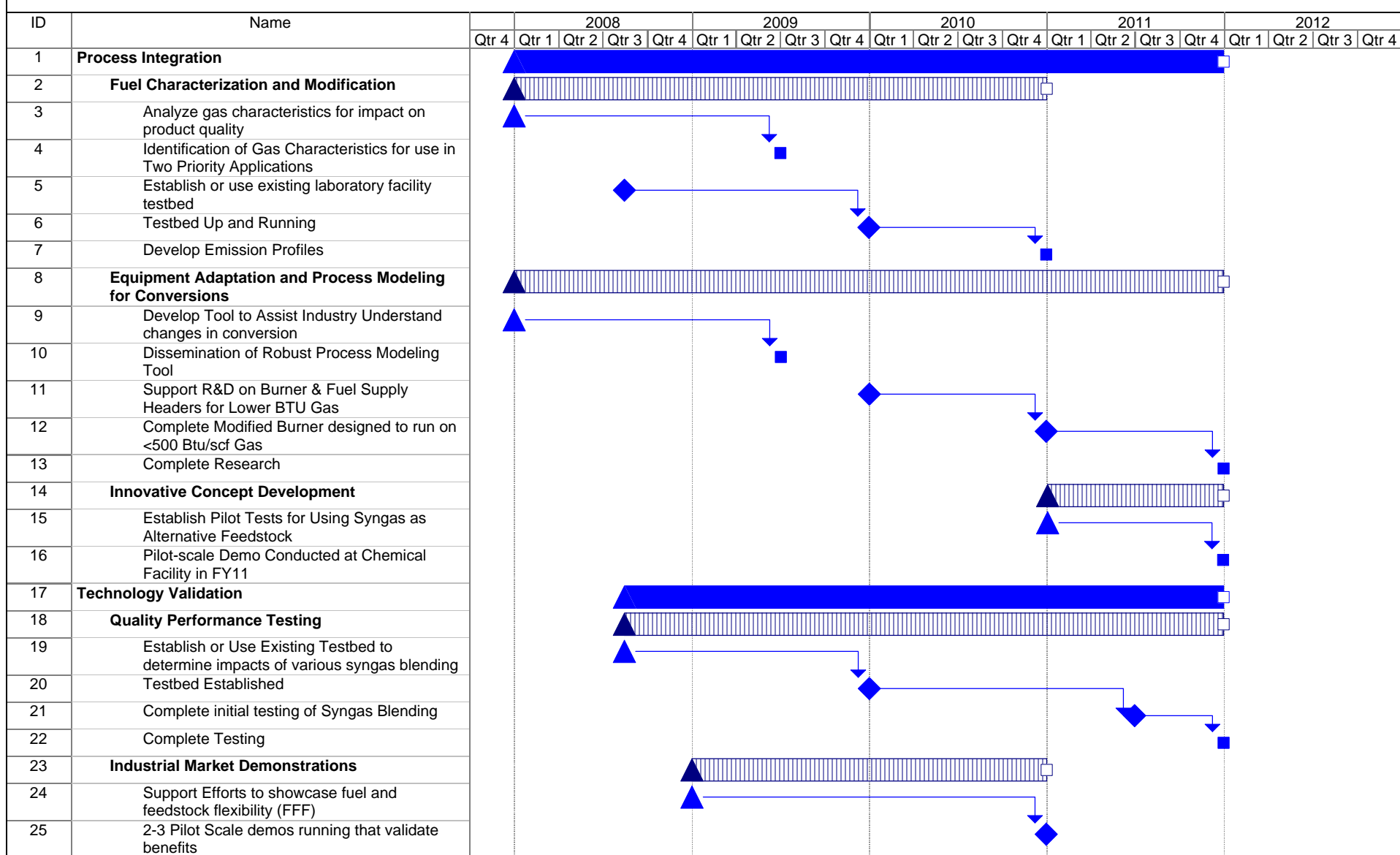
- ▶ Process Integration: Conduct technical research to develop fuel flexible hardware.
- ▶ Technology Validation: Demonstrate the effectiveness of fuel flexible technologies in strategic applications.
- ▶ Technology Platform Analysis & Education: Enhance knowledge among industrial decision makers, catalyze stakeholder collaboration, generate reliable data, and analyses.

- Due to the breadth of potential program activities and the limited amount of available funding, early activities will emphasize (i) facilitating the use of natural gas alternative sources, (ii) demonstrating the technology requirements that need to be performed in an industrial setting, (iii) facilitating alternatives to natural gas as a feedstock in the broader chemicals sector, and (iv) disseminating industry-derived information on the management of technical, economic and regulatory issues. Related to this last point, the program needs to assess its ability to create a broad set of actions such that the net result of the entire portfolio of actions reduces greenhouse gas emissions.

* Booz Allen Hamilton, "**Analysis of Fuel Flexibility Opportunities and Constraints in the U.S. Industrial Sector**," Draft, March 7, 2007, Prepared for the Industrial Technologies Program, Office of Energy Efficiency and Renewable Energy, United States Department of Energy

Last updated: 4/25/2008

FUEL AND FEEDSTOCK FLEXIBILITY



Focus Area	Barriers	Actions	Metrics/Milestones
Process Integration <i>Fuel Characterization and Modification</i>	Without greater understanding of how fuel and feedstock flexibility will affect the chemistry of existing processes, and especially regulatory agreements and permits, industry is reluctant to move to a more fuel flexible regime. Specifically regarding fuel characterization, end-users have concerns about a) how air emissions will differ from existing operations what impact that will have on environmental permitting; b) how to integrate lower heating value syngas into industrial processes; and, c) how best to remove impurities in syngas to avoid downstream fouling.	<ol style="list-style-type: none"> 1) Determine industrial issues and problems relating to use of alternative fuels. 2) Analyze impacts of alternative fuels on product quality. Document their gas and emissions characteristics and disseminate to industry. 3) Evaluate performance of fuel flexibility combustion systems, industrial burners, and advanced sensor and control systems. 4) Support R&D for processes for gas conditioning and for hot gas cleanup. 5) Develop and document options for variations in use of opportunity fuels and disseminate information to industrial end users and associations. 	<p>Develop a database of gas properties and emissions for alternatives to natural gas for industrial burners and other burner systems (FY08).</p> <p>Document impact of alternative fuels on product quality and the conditions for use in at least two priority applications (FY09).</p> <p>Develop technology option(s) for reducing emissions from combustion of alternative fuels to acceptable levels. (FY10).</p> <p>Establish or use existing laboratory scale test facilities to:</p> <ul style="list-style-type: none"> - Document data on performance, emissions and reliability of reciprocating engines under a range of fuels (FY10)
Process Integration <i>Equipment Adaptation / Optimization and Process Modeling for Technology Conversions</i>	Industrial end-users have concerns about the mechanical and technical challenges in moving to fuel flexible technologies. Specifically, they are concerned about a) identifying the technical challenges and potential solutions; b) integrating lower Btu gas with boiler equipment; c) dealing with impurities from coal liquefaction and biomass pyrolysis; and d) designing handling systems for co-feed materials.	<ol style="list-style-type: none"> 1) Create tools and/or models to address process conversion to opportunity fuels and optimizing system efficiency. 2) Support RD&D to design and test burner and fuel supply headers to run on lower Btu gas. 3) Support RD&D to prevent fouling of burners and boilers utilizing alternative fuels. 4) Support demonstration for more effective use of co-feed material handling systems. 5) Identify and clarify regulatory issues – such as those for wastewater, solids storage & handling, or feedstock harvesting – which may impede use of alternative fuels in direct fire and gasification. 	<p>Develop a process modeling tool to identify technical and process changes required during conversion to alternative fuel systems. Make model available to end-user industries (FY09).</p> <p>Complete design of modified burner to run on gas with Btu content of less than 500 Btu/scf (FY10). Validate burner equipment in field demonstration (FY11).</p> <p>Complete two pilot-scale demonstrations of co-feed material handling systems operating at efficiencies equivalent to conventional single-feed systems (FY10).</p> <p>Disseminate a guidance document for industry related to regulatory requirements (FY11).</p>



Focus Area	Barriers	Actions	Metrics/Milestones
Process Integration <i>Innovative Concept Development</i>	Industrial end-users lack advanced, innovative, commercially ready fuel flexible technologies.	<p>1) Support R&D for early-stage development of innovative fuel flexible technologies and identification of pathways to full-scale production and commercialization (e.g., gasifiers in the 30-70MW range).</p> <p>2) Evaluate syngas as an alternative feedstock for a bulk chemical production (other than in ammonia process or in smaller scale operations)</p>	<p>Complete concept development and market analysis for at least three innovative fuel flexibility technologies for industrial application that can match or exceed energy and cost efficiencies when compared to conventional technologies (FY11).</p> <p>Conduct pilot-scale demonstration from a slipstream or similar process that does not interrupt existing operations at a chemical facility to validate technical and economic feasibility (FY11).</p>
Technology Validation <i>Quality Performance Testing</i>	End-users who currently rely on the high heating value and high purity characteristics of natural gas for product quality cannot make the switch to a fuel flexible source without specific demonstrations to assure minimal impact on quality and performance.	<p>1) Evaluate impact of low and medium Btu syngas on product quality derived from process heating operations, with particular emphasis on production processes that rely on flame temperature for product quality</p> <p>2) Based on results of initial studies, convene a working group with gas owners & operators to examine issues and paths forward related to syngas/natural gas blending.</p>	<p>Complete testing and analysis of quality impacts from using low and medium Btu syngas in process heating operations, with particular emphasis on processes sensitive to flame quality (FY09).</p> <p>Establish or use an existing laboratory testbed facility to determine how much syngas can be blended with natural gas without adversely affecting air emissions, turbine performance, equipment performance, and reliability of industrial equipment, including boilers, and process heaters (FY10). Complete initial testing of syngas blending in testbed (FY11).</p> <p>Verify ability of lower-Btu syngas/natural gas blends to meet required user needs and determine optimum blending ratios (FY10).</p> <p>Workshop report on syngas/natural gas blending identifying R&D, market and commercialization issues and path forward (FY11).</p>



Focus Area	Barriers	Actions	Metrics/Milestones
Technology Validation <i>Industrial Market Demonstrations</i>	Without demonstrations of effective adoption of fuel flexibility and CHP technologies, industry managers are reluctant to undertake the financial risk of conversion.	Validate and showcase alternative fuels for process heating applications such as 1) CHP, 2) gasifying fuel sources such as petcoke into multiple product streams and 3) direct firing replacement of natural gas.	<p>Determine the technical and economic feasibility of fuel and feedstock flexibility by conducting 2-3 pilot-scale (or larger) demonstrations at industrial sites (FY10).</p> <p>Demonstrate at pilot scale (or larger) industrial equipment operating on landfill gas or other opportunity fuel (FY09).</p> <p>Demonstrate at an industrial site for at least one fuel source the technical and economic equivalence to natural gas. [(FY11).</p>



Supporting Activities	Barrier	Year Started	Description
<i>Studies & Analysis</i> <u>Objective</u> <i>Support R&D strategy decision-making by analyzing fuel and feedstock flexibility and R&D investment opportunities to maximize the subprogram's impact.</i>	The full technological options of fuel and feedstock flexibility are not understood in detail	FY08	Perform application assessment analyses for promising technology platforms (e.g., gasification using petcoke, MSW, etc; CHP using syngas or opportunity fuels; biomass combustion; electrotechnology.
	Use of electrotechnologies is constrained by the fact that electricity is more expensive per unit energy than natural gas and, depending upon the nature of the regional electricity market, may be as volatile or more so. Also many electro-technologies do not scale well in that there are little or no economies of scale above a given module size	FY08	Determine the geographic areas, types of industrial applications, and load profiles that characterize the best candidates for electro-technologies. Create a database of examples that model industrial users can apply to their operations to determine cost savings possible through use of electrotechnologies. Develop and best practices share economic and technical assessments based on actual data from process heaters units that should be targeted for replacement with fuel-flexible equipment. Examine life-cycle net energy issues related to electrotechnologies.
	Examine knowledge base of alternative feedstocks for bulk chemical production	FY10	Determine where there is technical and economic potential and interest in a pilot test of chemical production via an alternative feedstock.
	Regional resources and supply chain requirements related to biomass and petcoke present issues	FY10	Evaluate and analyze optimal combinations of gasifiers, feedstock, and specific applications with a regional focus to identify opportunities to use petcoke in close proximity to where it is generated.
<i>BestPractice Integration</i> <u>Objective</u> <i>Provide outreach to industry, garner input to the fuel flexibility strategy, and promote awareness and implementation of technologies.</i>	There is limited awareness of information related to success stories, which in turn limits end-users ability to apply information to other projects	FY08	Initiate data and delivery of efforts going on worldwide - consider web-accessible database and targeted workshops. MILESTONE: Conduct workshop, in FY08, to disseminate information as to the state-of-the-art in fuels and feedstock flexibility.
	Industry may be unaware of federal and state incentives available for advanced technologies	FY09	Assemble listing of financial incentives available for technology pathways. Financial risk guarantees for innovative projects. Determine the role of ITP in mobilizing EPA's loan guarantees in the industrial sphere.
	Not all fuel flexible options reduce project-specific carbon emissions	FY09	Determine way to evaluate and blend portfolio so that overall balance of carbon is neutral. Explore current activity with respect to carbon capture & sequestration and how it applies to industry, specifically with respect to locations where industrial CO ₂ can be used to enhance oil recovery (e.g. Texas).



2.1.11 Industrial Materials

Materials - (MAP21 - Materials and Processing for the 21st Century)

Background

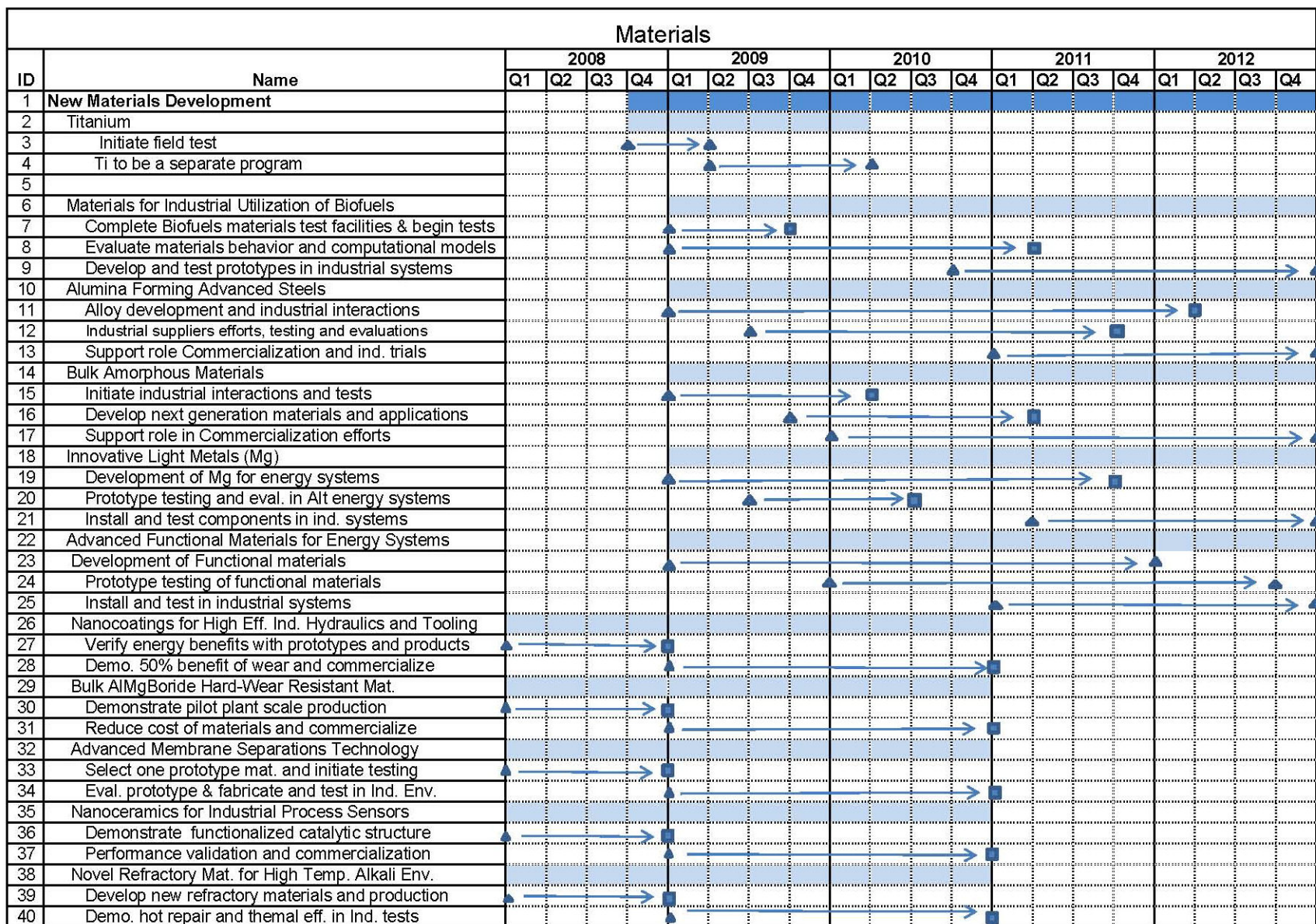
Materials are critically important to our nation in all areas including energy, economic and strategic security. Materials are and will be key in greatly improving our nation's energy efficiency and strategic positions while enabling decreased environmental impacts. The National Academies (NA) report on 1) Globalization of Materials R&D: Time for a National Strategy states “*Maintaining access to as well as generating cutting-edge science and technology is essential if the nation is to sustain economic leadership and a strong national defense capability.*” and “*The United States can gain from Materials Science and Engineering R&D globalization if it fosters increased productivity, efficiency, and a capacity for innovation*”. Also, the NA report Rising Above the Gathering Storm describes “*America must act now to preserve its strategic and economic security capitalizing on its knowledge-based resources, particularly in S&T, and maintaining the most fertile environment of new and revitalized industries that create well-paying jobs*”. Materials and designs are the framework of our capabilities and are critically important throughout all segments of the economy i.e. manufacturing, transportation (including ground, air, and infrastructure), buildings, infrastructure, power generation and defense.

Strategy

The Materials MAP21 program consists of three major technical areas **1) Advanced Strategic Materials 2) Thermal and Degradation Resistant Materials and 3) Advanced Materials for Energy Systems**. There is a critical need in industrial operations and other sectors of the economy for materials with much improved degradation resistance, compatibility, thermal properties, strength, and service life. In addition, new limitations are evolving in some of the newer materials and alloys in use today. The program will include both near term *breakthrough* activities and longer term *R&D* leading to *commercialization*. The R&D will lead to increases in the performance of current and modified materials and the development of new advanced materials. New materials opportunities and processing challenges, (fabrication, joining, and forming) include 1) low cost titanium, magnesium and copper which are coming to the forefront industrially due to the need for corrosion resistance, light weight and materials compatibility, 2) new alumina forming advanced steels to replace alloys made with strategic materials including Nickel and Cobalt, 3) materials in new manufacturing systems especially in regard to thermal management and on the use of biofuels for energy systems including industrial scale processing systems, engines, heating systems and power generation, 4) bulk amorphous materials that possess high degradation resistance and hardness, 5) innovative light weight high strength materials i.e. Mg, driven by fuel efficiency in the aerospace and transportation industries, 6) functional materials for energy systems including photovoltaics, light emitting materials, batteries, and thermoelectrics 7) ultrahard nanocoatings for hydraulics and tooling to reduce friction and wear, 8) bulk low cost processing of super hard - wear resistant materials, 9) advanced membranes for use in energy recovery from flue gas, 10) nanoceramics for use as industrial process sensors, 11) degradation resistant refractories for use in high temperature - high alkali processes, and 12) aerogel materials as highly efficient thermal insulation. For example, traditional industrial applications for titanium include desalination, automotive, petrochemical, chemical, and heat exchanger, due to its inherent properties while the aerospace demand has driven the costs to record highs. The need for titanium is projected to potentially triple by 2015 and the automotive sector has identified magnesium as a key material in meeting its fuel efficiency goals. Magnesium, the lightest structural metal, offers one of the greatest opportunities for reducing vehicle weight. Several organizations, including the American Foundry Society and the United States Automotive Materials Partnership, have produced roadmaps for the development of magnesium for automotive applications. Efforts in the program will be in concert with DOE EERE, Bioenergy, Buildings, Solar, and Transportation; DOE OS; NSF and DOD).

Last updated: 02/18/2008





R&D Focus Area	Barriers	Pathways	Metrics
New Materials Development <u>Objective</u> Develop new materials that will require less processing in producing them and benefit user industries by increasing industrial process energy efficiencies, improving operational characteristics in use, extending service life, and be more economical to use.	1. Lack of low cost Titanium and Magnesium with useful industrially relevant end use properties 2. Lack of knowledge of the effects of biofuels on industrial processing systems and equipment 3. Lack of knowledge on the cause/s of degradation issues with currently available select alloys and the lack of economical next generation alloys 4. Lack of manufacturing capabilities in being able to produce and utilize bulk amorphous alloys 5. Lack of the availability of light metals and alloys able to meet critical requirements in future industrial applications 6. Current materials lack characteristics required for economical advanced batteries, thermoelectrics, photovoltaics, and light emitting materials 7. Ineffective or unavailable corrosion, erosion, and wear-	1. Develop manufacturable Titanium alloys and components from new low cost powder technology. 2. Develop a) testing and modeling capabilities to determine the affects of biofuel and biofuel additions on industrial process equipment and b) modify or develop new materials to enable the use of biofuels in industry 3. Develop new economical alumina protected steel alloys to outpace nickel alloys in capability. 4. Develop bulk amorphous materials to enable less friction and wear in industrial processes and equipment. 5. Develop industrial processes and manufacturable light metal Magnesium alloy components. 6. Develop materials that meet industrial scale manufacturing and end-use requirements 7. Develop robust ultrahard materials that can survive and keep their	1. Enable 50% more energy efficient production of Ti alloy sheet and also reduce cost by up to 75% 1. Reduce energy use (fuel) of aerospace transportation sector by 20% (~100Tbtu/yr); (In concert with DOD) 1. Reduce energy use (oil) of land based transportation by 20% (in concert with EERE Transportation and DOD. (2012) 1. Reduce energy use and enable large scale water purification – desalination by 20% (In concert with DOD) 2. Develop biofuels materials degradation facility and begin materials testing. (2008) 2. Enable biofuels substitution in national industrial and transportation system (In concert with EERE Bioenergy, EERE Transportation and DOD). (2009) 3. Develop alumina forming advanced steel alloys and evaluate their behavior in industrial trials. (2010) 3. Enable 15% energy benefits in production systems through improved operations and less corrosion (~100Tbtu/yr)(2020) 4. Complete industrial testing and initiate commercialization of new bulk amorphous materials. (2010) 4. Enable up to 30% improvement in operations and end use applications using hard materials and low friction components 5. Complete industrial testing and initiate commercialization of new low cost Magnesium alloy sheet and near net shape processing. Enable 30% energy benefits. (In concert with EERE Transportation and DOD) (2011) 6. Enable 2X conversion efficiency gain and 2x less manufacturing costs (2014); develop light emitting materials with up to 15X improvements over current systems (2014) 7. Validate AlMgB14 nanocoating and powder processing technologies. Verify energy savings from friction reduction for



	<p>resistant coatings.</p> <p>8. Technology for economic, bulk processing of super hard materials and fabrication of components not currently available.</p> <p>9. Lack of adequate membrane and catalyst materials for energy efficient, high performance separations and chemical processing.</p> <p>10. Lack of reliable sensors and control systems for real time feedback control of combustion processes and burner efficiency</p> <p>11. Ineffective or unavailable high-temperature materials and refractories for optimum performance processing.</p> <p>12. High levels of energy loss from industrial process streams, exhaust gases and fluids, containers, and equipment.</p>	<p>qualities in harsh mechanical and chemical processing environments.</p> <p>8. Develop AlMgBoride bulk materials (New Start 2007)</p> <p>9. Develop and evaluate membrane and substrate materials with sufficient corrosion and fouling resistance to water vapor from industrial gas streams (New Start FY2007)</p> <p>10. Development of nanoceramic materials for novel sensors for combustion optimization in industrial processing. New Start (FY 2007)</p> <p>11. Reduce energy losses through development of advanced refractories for boilers, furnaces and kilns.</p> <p>12. Develop manufacturing and installation protocols for application low thermal conductivity nanoporous, aerogel insulation to industrial systems. (FY2007)</p>	<p>both hydraulic and tooling systems by using test prototypes with real product geometries. (2008)</p> <p>7. Demonstrate 50% improvement in friction and component life for ultra-hard boride coated tools and hydraulic components (2010)</p> <p>8. Demonstrate manufacturing technology commensurate with prototype scale quantities (e.g., 1,000 Kg/month) of wear-resistant boride powder at a cost not to exceed \$299/Kg will be formulated (2008) enabling commercial introduction of ultra-hard boride materials (2011).</p> <p>9. Identify materials for membranes and substrates with heat and mass transfer sufficient to increase condensing water flux by 50%; plus toughness, ductility, corrosion resistance, and fouling resistance sufficient to operate in industrial environments. Select one prototype material for evaluation in the industrial environment for which it was developed (2008)</p> <p>9. Fabricate and test prototype Transport Membrane Condenser system for recovery of heat and water from low-temperature process streams (2010)</p> <p>10. Performance validation of a prototype sensing element in a simulated service environment for closed-loop, feedback control of industrial combustion with increased efficiency $\geq 0.5\%$ with fuel savings ≥ 24 trillion Btu/yr (2009)</p> <p>11. Develop new prototype refractory materials production and applications techniques for refractory systems with improvements of 20% in thermal efficiencies and $\geq 100\%$ in life span (2008)</p> <p>11. Validate life span and thermal efficiency performance of advanced refractories in plant field tests (2010)</p> <p>12. Extend maximum use temperature of aerogel insulation to 1200F, and reduce estimated production cost by approximately 10%. Complete in-service tests of prototype materials to validate performance (2008) (Project ending in 2008)</p>
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Supporting Activities	Description
<p>Studies & Analysis</p> <p>To inform programmatic planning and decision - making.</p>	<p><u>Globalization of Materials R&D: Time for a National Strategy</u>, The national Academies, Aug 2005</p> <p><u>Broad Federal Effort Urgently Needed to Create New, High-Quality Jobs for All Americans in the 21st Century</u>, NEWS, The national Academies, 2005</p> <p><u>Rising Above the Rising Storm</u>, The national Academies, 2005</p> <p><u>Industrial Technoloiges Program Research Plan for Energy Intensive Industries</u>, Battelle, Oct. 2007</p> <p><u>Industrial Markets for Titanium Manufacturing Energy Consumption and Impact of Lower Cost Processing</u>, EHK Technologies, 2007</p> <p><u>Energy Efficient, Economical Titanium and Titanium Alloy Production Using New, Low Cost Titanium Powders</u>, ORNL 2007</p> <p><u>Assessment of Market and Commercial Opportunities for Ultra hard Materials</u>, Delta Research, MMPaCT, 2007</p> <p><u>Engineering Scoping Study of Thermoelectric Generator Systems for Energy Efficiency Improvements of Industrial Manufacturing Processes</u>, PNNL & BCS, Inc., September, 2006</p> <p><u>Opportunity Analysis for Recovering Energy from Industrial Waste Heat and Emissions</u>, PNNL, April, 2006</p> <p><u>Energy Impacts of Corrosion</u>, Energetics, Inc., September, 2005</p> <p><u>Refractories for Industrial Processing: Opportunities for Improved Energy Efficiency</u>, ORNL and BCS, Inc., December, 2005</p>
<p>Technology Delivery</p> <p>Success Stories (Available on web).</p>	<p>Case Studies:</p> <ul style="list-style-type: none"> • Development and Demonstration of Advanced Tooling Alloys for Molds and Dies: A Technology Transfer and Commercialization Case Study of RSP Tooling (April 2005) • Advanced Materials for the Pulp and Paper Industry (2005) • Intermetallics for Manufacturing (2005) <p>Recent Highlights:</p> <ul style="list-style-type: none"> • Award Winning Treatment Process Hardens Stainless Steels and Improves Corrosion Resistance (December 2006) • Development of R&D 100 Award Winning Alloys Resistant to Metal Dusting (October 2006) • Real-Time Characterization Project Addresses a Priority Need in Nanomanufacturing (October 2006) • Metal Infusion Surface Treatment (MIST) Technology Wins R&D 100 Award (July 2006) • New Software Tool Identifies Opportunities for Energy Savings in Galvanizing Lines (June 2006) • Novel Ceramic and Refractory Components (March 2006) • Corrosion Resistant Materials for Molten Metal Processing (February 2006)
<p>Cross-EERE Activities</p>	<ul style="list-style-type: none"> • Our Solar Future, The US Photovoltaic Industry Roadmap for 2030 and Beyond, US DOE, EERE, Solar Energy Technologies Program (Sept. 2004) • Energy Savings Potential for Slid State Lighting in General Lighting Applications, rthur D. Little, Inc., Office of Building Technologies, US DOE, (April 2001) • Annual DOE Energy Materials Coordinating Committee (EMaCC) Report • Organize Annual Inter-Agency Communications and Coordination Meeting on Metals Research



2.1.12 Combustion

Background

Combustion systems are used to generate steam and heat for use in vital manufacturing processes, to heat processing materials as diverse as metals and chemical feedstocks, and to change the mechanical and chemical properties of materials and products. These functions are critical to the production of basic manufactured goods used in all segments of the U.S. economy.

The performance of an industrial combustion system is generally determined by the performance of individual boiler or furnace subcomponents and the compatibility of various component technologies within the overall system design. The challenge is to optimize energy efficiency, operating and capital costs, and compliance with emission regulations at the same time in the face of the following challenges:

- Boiler and furnace system design parameters are inter-related and interdependent,
- Pushed to extreme performance, new problems will occur (control, safety, and durability),
- System integration and component compatibility issues are complicated, and
- One single conventional technological approach will not meet all needs, so that many different technology platforms are needed.

ITP's "Energy Use and Loss Analysis" estimates 400 trillion Btu of savings could be achieved through the development and deployment of advanced boilers alone. Combustion R&D currently centers on steam generation.

The Combustion subprogram is being transferred into the Energy Intensive Processes Program Area. Program components will be most included in the Waste Heat Minimization and Recovery Platform. The main intent of combustion related activities remain the same.

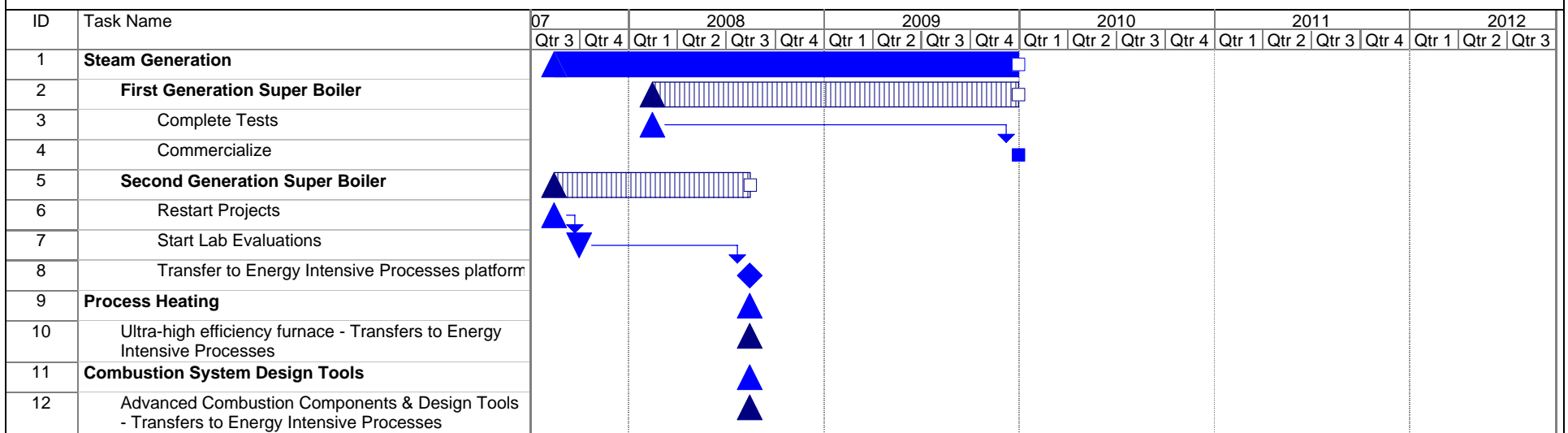
Strategy

The Combustion subprogram supports a portfolio of cost-shared, pre-competitive R&D projects to develop advanced technologies that will improve the energy efficiency of fired industrial systems. Fired systems consume approximately two-thirds of the energy used by industry. The focus of the portfolio is on R&D that is too risky for industry to fund alone yet will have high impacts on industrial energy use. Projects in the portfolio are focused on developing both revolutionary technologies and incremental improvements to existing processes, thereby addressing both long-term goals and short-term opportunities to improve energy efficiency.

The Combustion program is currently focused on steam generation. Technical barriers, metrics, and goals were identified through interaction with private sector stakeholders. ITP then defined R&D pathways appropriate for federal funding. These pathways will lead to the development of competitive technologies that will improve the efficiency of industrial manufacturing by reducing energy use, lowering emissions, improving productivity, and lowering capital and operating costs.

Last updated: 5/9/08

COMBUSTION



Focus Area	Barriers	Pathways	Metrics
Steam Generation (1) Note: Super Boiler is also discussed under "Waste Heat Minimization and Recovery")	<ul style="list-style-type: none"> Available heat exchangers and waste heat recovery technologies have high capital and installed costs. With current technology, it is difficult to simultaneously reduce emissions and increase efficiency. Conventional technologies can not be easily adapted to the diversity of many different boiler design configurations. Advanced burner developed for a particular boiler design may not transfer successfully to other boilers. The turndown instability of lean premixed combustion systems is a barrier to reducing NOx emissions. (2) 	Combustion currently funds the development of an ultra high-efficiency, ultra low-emission packaged firetube boiler. This "Super Boiler" technology will be applicable to very broad industrial steam generation uses. It will achieve 95 percent energy efficiency while producing only 5 parts per million nitrogen oxides and carbon monoxide emissions. A suite of component technologies including an ultra-low NOx burner, a high-intensity heat exchanger, an advanced transport membrane condenser for latent heat recovery, and a smart control system are packaged together on a new boiler platform. The individual technology components developed under this project will be retrofittable to many types of existing boilers. The first generation "Super Boiler" is currently being field tested. Research on the second generation "Super Boiler," with a watertube configuration, same efficiency and emissions goals, has been initiated. A Multi-Staged Printed Circuit Boiler for Industrial Applications is also being developed.	Develop firetube boilers with >94% fuel to steam efficiency, <5ppmv NOx and CO, and 50% reduced size and weight. Develop watertube boilers with >94% fuel to steam efficiency, <2ppmv NOx and CO, and 50% reduced size and weight. The watertube Super Boiler project will be merged with the Waste Heat Minimization and Recovery Platform in the Energy Intensive Processes Program Area. <i>Total potential savings = 226 trillion Btu/year</i>
Process Heating (1)	<ul style="list-style-type: none"> Low compatibility of various combustion components within a furnace system. Unreliable component technologies when operated at maximum performance limits. High level of integration of industrial heating equipment with the other manufacturing process steps within a plant compromise system efficiency. Narrow focus on specific designs on conventional process heating furnaces. (4) 	A high efficiency Integrated Process Heater has been developed for the petroleum and chemical industry. This technology utilized sophisticated CFD modeling in the early phase of the furnace system design and component integration compatibility evaluation. The CFD modeling effort enabled this integrated process heater to achieve extremely uniform temperature distribution and improve the overall efficiency over conventional furnaces. An ultra low NOx burner with natural draft air was incorporated into the combustion system design. The process heater has been designed and is projected to exceed 95% efficiency with NOx below 10 ppm. This research is complete. An ultra high efficiency furnace will be developed and tested under the Waste Heat Minimization and Recovery Platform.	This activity has ended. Future Process heating activities will be conducted within the Waste Heat Minimization and Recovery Platform of the Energy Intensive Processes Program Area.



Focus Area	Barriers	Pathways	Metrics
Combustion Components and Design Tools (1)	<ul style="list-style-type: none"> • No reliable design tools to predict the efficiency and safety performance of new combustion systems. • Inaccuracy of CFD models for furnace flame predictions due to lack of understanding of the effects of turbulent flow on combustion chemistry. • Inadequate technologies for measuring and controlling key combustion parameters for ultra low emissions. • Limited performance on conventional waste heat recovery technologies.(4) (5) 	Current R&D projects include the development of Advanced Diagnostics and Control for Furnaces, Fired Heaters and Boilers.	<p>Develop a model for managing the combustion characteristics of a chemicals process heater that will result in an increase in efficiency of at least 10%.</p> <p>This activity is ending. Specific elements will be incorporated in the Waste Heat Minimization and Recovery Platform of the Energy Intensive Processes Program Area.</p>

Sources

- (1) U.S. Department of Energy, Energy Efficiency and Renewable Energy, Office of Industrial Technologies, Industrial Combustion Vision, Washington DC, May, 1998, pg. 7.
- (2) U.S. Department of Energy, Energy Efficiency and Renewable Energy, Office of Industrial Technologies, Industrial Combustion Technologies Roadmap, Washington DC, July 2002, pgs. 19-24.
- (3) Industrial Technologies Program Government Performance and Results Act Report, Fiscal Year 2005, Energetics Incorporated, December 2003, pg. 24.
- (4) U.S. Department of Energy, Energy Efficiency and Renewable Energy, Office of Industrial Technologies, Industrial Combustion Technologies Roadmap, Washington DC, July 2002.
- (5) U.S. Department of Energy, Energy Efficiency and Renewable Energy, Office of Industrial Technologies, Workshop Report, "Improving Industrial Burner Design with Computational Fluid Dynamics Tools, pgs. 15-16.



2.1.12.1

Technologies	Combustion Roadmap	Description
T1. Waste Heat Recovery		
	Combustion Air Preheating	Waste heat transfer to incoming air stream by using cost-effective heat exchanger designs.
	Condensing Heat Exchanger	Extract sensible and latent heat from flue gases by cooling the flue gases below the water vapor dew point.
	Integrated System Design for Waste Heat Recovery	Design new systems to enable integrated waste heat recovery to reduce cost of waste heat recovery.
	Hydrogen Generation	Produce H ₂ by using waste heat as an energy source for a fuel reformer.
	Organic Rankine Cycle	Use low temperature waste heat to power a rankine cycle and generate electricity.
	Absorption Refrigeration	Use waste heat conversion to refrigeration.
	Feedstock Preheating	Transfer waste heat to incoming feedstock
T2. Low Emission Combustion		
	Improve Flame Stabilization	Enable operation of burners with fuel/air/flue gas ratios that significantly reduce NO _x emissions.
	Flame Sensors	Burner balancing and tuning for low emissions based on feedback from individual flames
	Flue Gas Emission Sensors	Low cost emissions sensors that allow burners to operate at lower excess air and with low emissions.
T3. Design and Development Tools		
	Enhanced Computational Fluid Dynamics(CFD) Models	Improve development and design precision based on predicted flow, heat transfer and chemistry
	Validation Facilities	Confirm enhanced CFD predictions with pilot-scale testing.
	Integrated Modeling	Models that can be used for real-time optimization of furnaces and boilers.



Technologies	Description
T4. Performance Optimization and Controls	
Integrated Designs	Integrate combustion heat recovery systems with furnace/boiler configuration.
Optical Temperature Sensors	Optimize furnace operation based on feedback from workpiece sensor.
Uniform Heat Flux Distribution	Shape flame for optimal heat transfer to load
Flame property sensors	Modify flame shape or composition based on feedback properties
Real time burner adjustment	Integrate sensors with burner control system to optimize performance in real-time.
High temperature materials	Materials with cross-cutting use such as durable, high temperature refractories, corrosion resistant heat exchanger materials and high temperature metal alloys.
Industry specific process quality controls	Improved control of product quality and yield.
Model based control	Tune process operation based on predicted performance.
T5. Novel Processes	
Oxygen enriched combustion	Reduce process size, emissions and heat loss with oxyfuel combustion.
Biomass derived fuels	Replace or augment fossil fuels with renewable biomass fuel
Fuel flexibility	Ability to utilize multiple fuels while maintaining emissions and performance.
Integrated optimized heating system	A modular heating system that can be applied in a wide range of industrial processes.



Background

The overall goal of ITP's crosscutting Sensors and Automation portfolio is to identify, develop and deploy integrated measurement systems for operator-independent control of manufacturing processes. These real-time on-line systems can be used by more than one industry and are fully compatible with the harsh industrial environment. Ultimately, systems will enable a level of productivity and product quality currently unattainable under human or machine control and produce a gain of at least 5% in energy efficiency. The Program's focus is on optimizing *systems* rather than developing individual components.

Strategy

After nine years in which seven ITP sensor portfolio technologies were commercialized, and are in use saving energy for industry, the ITP sensors activity is now in transition. The following will occur as a result of this transition:

- Existing Projects: Existing projects are being funded to completion.
- Commercialization/Deployment: By design, and as required by S&A, awardee teams are experienced in the manufacture and marketing of the types of technologies associated with their projects. ITP assistance to accelerate industry adoption is being provided through completed project fact sheets, success stories, technology readiness assessments and promotion at industry events.
- Legacy: S&A fact sheets, energy analyses, workshop output, and portfolio review presentations and documentation will be maintained on the ITP web site.
- Future: Sensors and industrial control systems will be incorporated into crosscutting technology platforms as appropriate.

S&A has been focusing on high payoff crosscutting technologies in three focus areas 1) advanced sensor technologies, 2) system performance monitoring and optimization, and 3) robotics. S&A fosters commercial introduction of its technologies by requiring for each project, partners for R&D, manufacturing the technology produced by the R&D, marketing that technology and, end user hosting to demonstrate the technology. All projects are cost shared, generally at 50%.

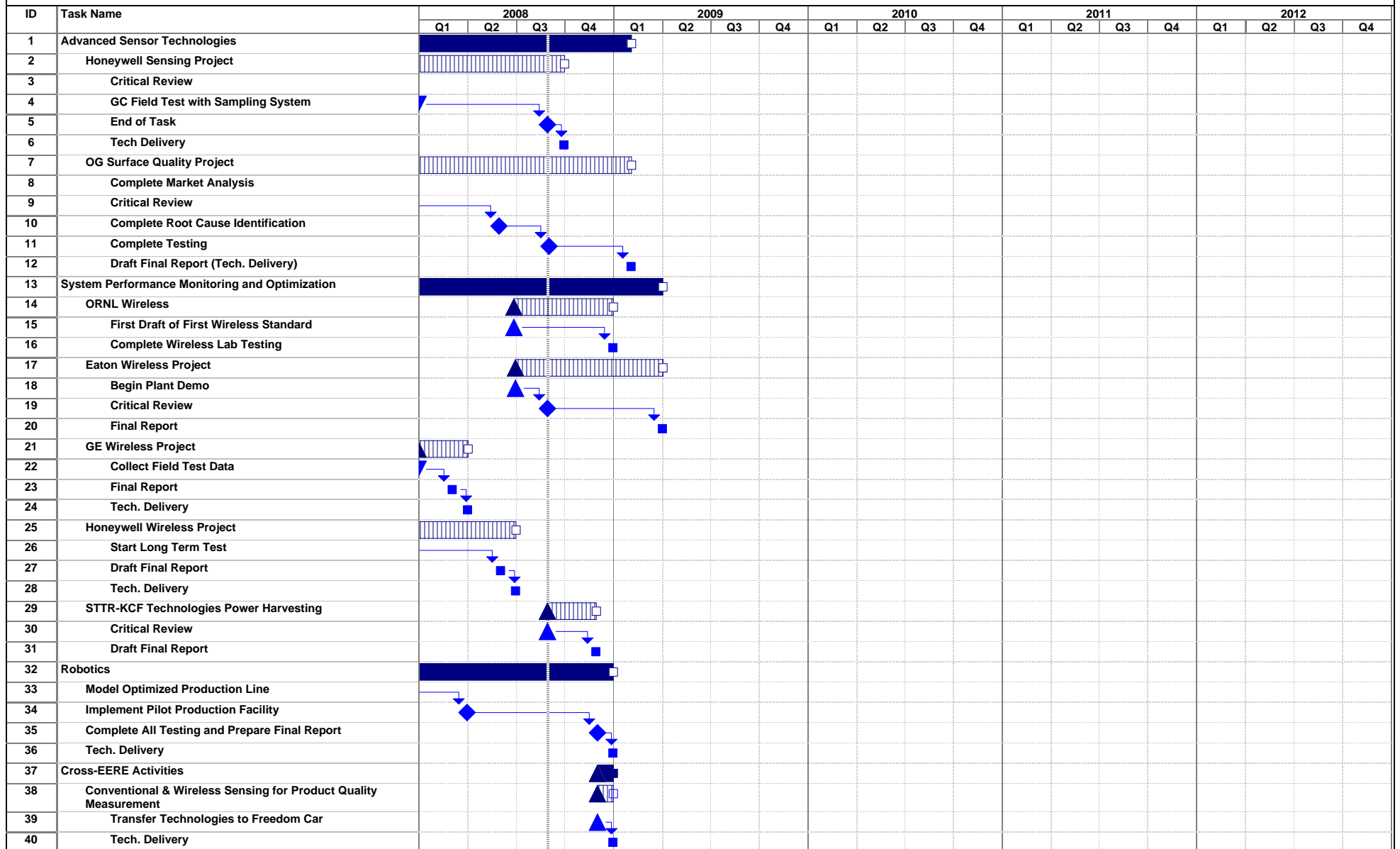
1) Sensors along with control systems are the cornerstone of modern industrial production. Sensors in concert with control systems provide the lowest cost route to energy savings through increased productivity and improved product quality. Sensors can be used to supply information to process control systems and can be used to establish the operating efficiency and "health" of industrial manufacturing infrastructure. Current sensor focus is on machine vision and microelectro mechanical system (MEMS) replacements for classic sensing systems. The goal is to improve product quality there-by reducing sub-par production ("rejects"), reducing the amount of product that is recycled, and consequently saving energy.

2) "Smart" systems will enable a level of productivity and product quality currently unattainable under human or machine control and produce a gain of at least 5% in energy efficiency. S&A is developing technologies that will facilitate the use of smart systems by more than one industry and in harsh industrial environments. For example, industry is turning to wireless technology as it continuously seeks to reduce costs, while realizing the productivity gains possible with advanced sensor and control systems. Wireless sensor systems hold the potential to help U.S. industry use energy and materials more efficiently, lower production costs, and increase productivity. Although wireless technology has taken a major leap forward with the boom in wireless personal communications, applications to industrial sensor and control systems must meet some distinctly different challenges. Presidential advisors have forecast that ubiquitous wireless sensors can improve production energy efficiency by 5 to 10%. Despite the technological advances resulting from cell phone development, many challenges remain before wireless systems can operate successfully in an industrial environment: security, interference rejection and long lasting wireless power, to name a few. These problems exemplify the R&D needs which must be met before wirelessly directed production lines can become reality.

3) Robots are flexible, taskable and reprogrammable manipulators. Virtually every S&A discipline can contribute toward making a robotic system successful. Many of the technologies associated with sensing and measurement, process control and automation are applicable to robotics. A robotic system can be thought of as a programmable mechanically articulated device that works to enhance the efficiency of a system which normally operates in the manual mode. A key difference between robotics and automation is that robotic systems are usually reprogrammable to accomplish different tasks while automation systems generally are not. A robotic system can enable the replacement of continuously run furnaces with on-demand induction heaters, reducing energy consumption by at least 25%. The strategy utilized in S&A's current robotics project is to create a robotically enhanced manufacturing line (REML) in which high-temperature compatible labor robots perform repetitive manufacturing steps that will allow the replacement of continuously run furnaces with on-demand induction heating. The final efforts will include documentation of opportunities for energy reduction (a 22% energy saving has been shown), productivity and environmental impact improvements associated with REML implementation in roller bearing production

Last updated: 5/5/2008

Sensors & Automation



R&D Strategy Focus Areas	Barriers	Pathways	Metrics
<p>Advanced Sensor Technologies</p> <p><u>Objective</u></p> <p>Create commercially viable, industrially compatible sensors for use in process and equipment monitoring and process control.</p>	<ol style="list-style-type: none"> 1. Capital investment. 2. Sensor robustness and compatibility with the industrial environment. 3. Overly sophisticated sensors and control systems requiring operation by technically sophisticated personnel. 4. Inappropriate user interface 5. Lack of cost-effective, reliable, robust sensors to monitor the process goal directly (e.g., sensors which measure temperature of workpiece, not of the furnace). 	<ol style="list-style-type: none"> 1. Complete development of process gas composition analyzer, couple with standardized sampling system and evaluate performance at industrial sites. Complete installation of microanalyzer at operating field sites (Q3-FY08). <p>Use the following guidelines for sensors development:</p> <ul style="list-style-type: none"> - Improve sensor capabilities and performance by following laboratory evaluation with plant production line testing and long term performance evaluation. - Make sensors compatible with the industrial environment. Specifically, sensors which are real-time, on-line and non-intrusive and which are fully compatible with the industrial environment is a long term goal. - Structure each project to enhance the likelihood of industrial adoption: each project team must include a member R&D organization plus an organization that is experienced in manufacturing the type of technology under development, an organization with experience in marketing the technology to the target market and a host site where the technology will be evaluated and demonstrated. 	<ol style="list-style-type: none"> 1. Demonstrate improved process control due to use of micro gas composition analyzer resulting in energy savings of 1-5% depending on the application. <p><i>Total potential savings = 8 trillion Btu/year</i></p>

R&D Strategy Focus Areas	Barriers	Pathways	Metrics
System Performance Monitoring and Optimization <u>Objective</u> Develop open architecture, non-proprietary wireless sensor systems that are competitive with wired systems in performance and cost.	1. Limited performance characteristics and capabilities of current systems. 2. Limited sustained performance of current systems. 3. High cost of current systems 4. Perceived lack of security in wireless sensor systems. 5. Lack of applicable standards for reliable, robust wireless sensor networks.	1. Identify/modify/devise wireless systems meeting functionality, reliability and performance goals. 2. Create power system that matches wireless sensor system life - Identify battery + power management circuitry - Extract power from environment using power harvesting. 3. Facilitate development of standards for industrial wireless sensor networks which assure security..	1. Demonstrate the prompt identification of sub-performing, inefficient motors, saving 3-10% of electricity use of the motors for which this technology is applicable. <i>Total potential savings = 36 trillion Btu/year</i>
Robotics <u>Objective</u> Use robots to enable use of on demand induction heating in manufacture of roller bearings.	1. Uniform induction heating to cover range of workpiece geometries. 2. Shielding that minimizes electromagnetic flux leakage 3. A means to sense, grip and accurately position workpiece in induction heater	1. Develop a robotically enhanced manufacturing line (REML). Establish range of tooling, coils and heating recipes to heat workpiece uniformly. Identify and evaluate shielding candidates. Develop an approach to optimize robot gripper force and minimize heated workpiece distortion and heat transfer.	1. Reduce energy consumption on a small-lot production line by 5-30% (depending on the application). <i>Total potential savings = 1 trillion Btu/year</i>

Supporting Activities	Sources
Studies & Analysis <u>Objective</u> Support R&D strategy decision making by analyzing energy savings and R&D investment opportunities to maximize the subprogram's impact on American industry.	<p>1. <u>Industrial Wireless Technology for the 21st Century</u>, 1Q 2003, is a vision document reporting results of a workshop attended by users and producers of wireless systems and components. This widely acclaimed document continues to guide S&A wireless sensor activities.</p> <p>2. <u>Assessment Study on Sensors and Automation in the Industries of the Future: Reports on Automation, Industrial Control, Information Processing and Robotics</u>, 1Q 2005, presents the results of four coordinated studies to identify possible new focus areas for S&A. Inferential process control was recommended by two of the four sectors analyzed and was chosen as an S&A focus area. This report is posted on the S&A web site.</p> <p><u>Sensors, Control Systems, Information Processing and Robotics: Enabling Process Change</u> reported on the results of a workshop held in 3Q FY 2005 to identify future S&A developments which could result in energy saving process changes in existing processes and would make feasible the effective operation of emerging processes. The completed report will be posted on the S&A web site.</p> <p>The detailed <u>Workshop to Identify R&D Topics on Inferential Process Control</u> was held in 2Q 2006. It provides detailed guidance to enable ITP S&A to convert inferential process control from a concept into an important transformational technology to be used by industry.</p> <p><u>Robotics in Manufacturing Technology Roadmap</u> resulted from a workshop that was held during 3Q 2006 and identified logical steps to advance and coordinate the R&D and application of robotics to American industry. The roadmap to be used by industry in advancing industrial robotics. Roadmap elements that overlap ITP goals would guide any future S&A robotics activities.</p>
BestPractice Integration/Technology Delivery <u>Objective</u> Promote American industry awareness of energy efficiency and awareness of the availability and benefit of S&A technologies	<p>The FY 2007 annual portfolio peer review of the Sensors & Automation (S&A) activity was held at Sensors Expo. Sensors Expo, a conference and trade show that typically attracts over 5000 attendees, was held this year at the Rosemont, Illinois convention center on June 12-14. It was an excellent location to make industry aware of the energy saving technologies emerging from S&A. The major emphasis this year for the entire conference was on wireless sensor systems such as those which are now emerging from S&A sponsorship. The portfolio review attracted an interested audience which was 25% larger than the previous year. (The FY 2006 portfolio review was also held at Sensors Expo.) ITP S&A partners described energy savings which can result from the application of wireless sensor condition-based monitoring systems to electric motors, steam systems and other manufacturing infrastructure. Illustrating that cost is the major driver to adoption of this energy saving, enabling technology, industry is looking to wireless sensor use to result in fewer costly process upsets and unexpected shut downs.</p>

2.1.14 Technology Delivery

Technology Delivery supports the mission of the Industrial Technologies Program (ITP) through the development, implementation and dissemination of Best Practices in energy management that realize the best energy efficiency and pollution prevention options from a system and life-cycle cost perspective. Technology Delivery targets both energy-intensive large and small-medium sized manufacturing facilities in the United States. The activities currently funded under Technology Delivery make-up the bulk of the Save Energy Now initiative.

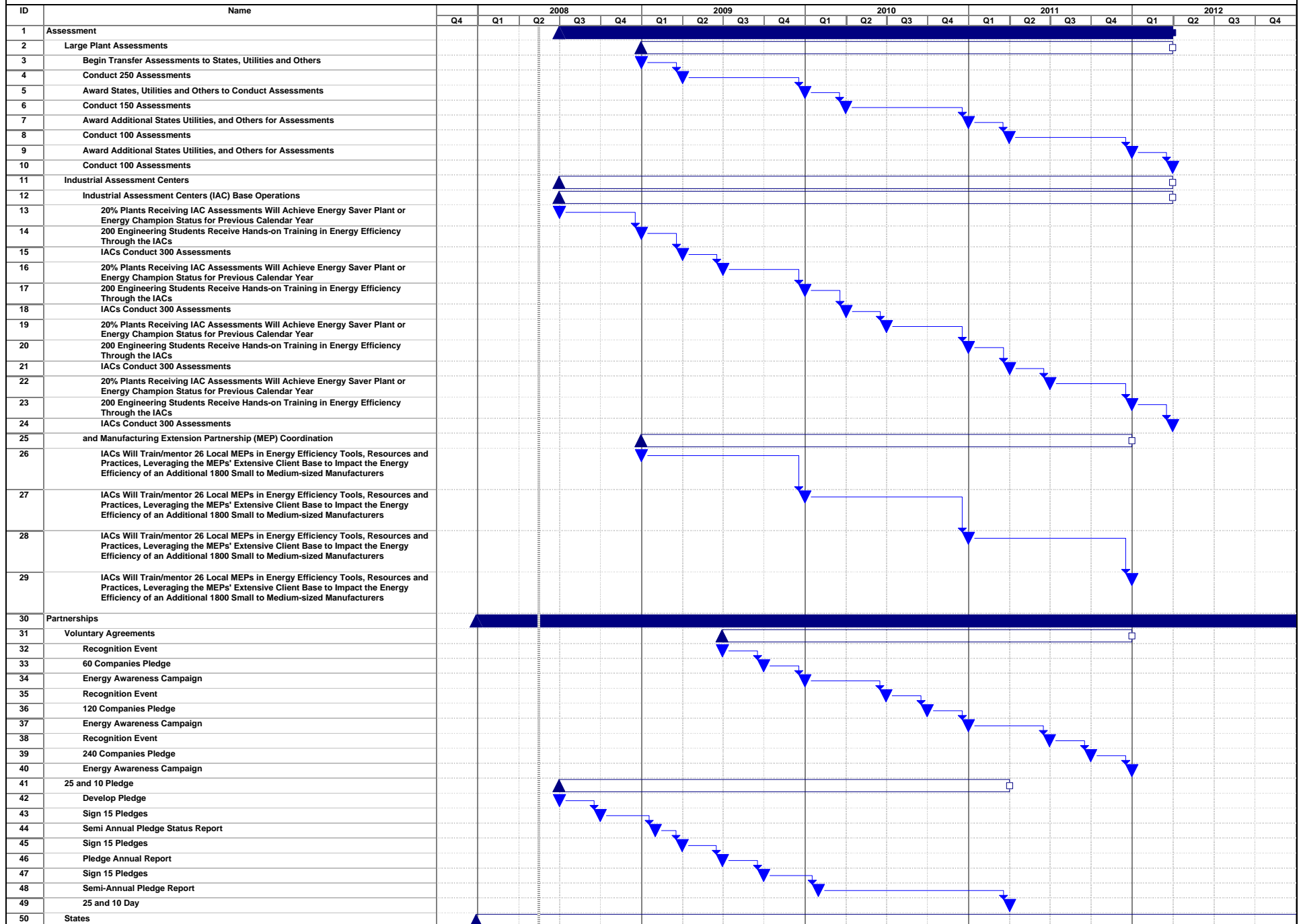
Technology Delivery conducts a wide range of energy savings assessments in manufacturing facilities; some system specific in primarily large facilities and through the Industrial Assessment Centers in small-medium sized plants. Technology Delivery encourages replications of assessment results and methodologies particularly in the largest 4,000 manufacturing plants that consume about 58 percent of the manufacturing energy. Technology Delivery also develops system tools to analyze facility energy use and develops and delivers accompanying training aimed at plant floor personnel who can implement the system improvements. Key to the Technology Delivery program area is a robust set of partnerships with entities that are best suited to reach the largest number of manufacturing facilities; State Energy Offices, utilities, and key industrial trade associations are being tapped to promote Save Energy Now and encourage project implementation to enhance energy savings.

Technology Delivery recognizes industrial plants that have acted upon and implemented energy saving recommendations from Save Energy Now and IAC energy savings assessments in a formal recognition program.

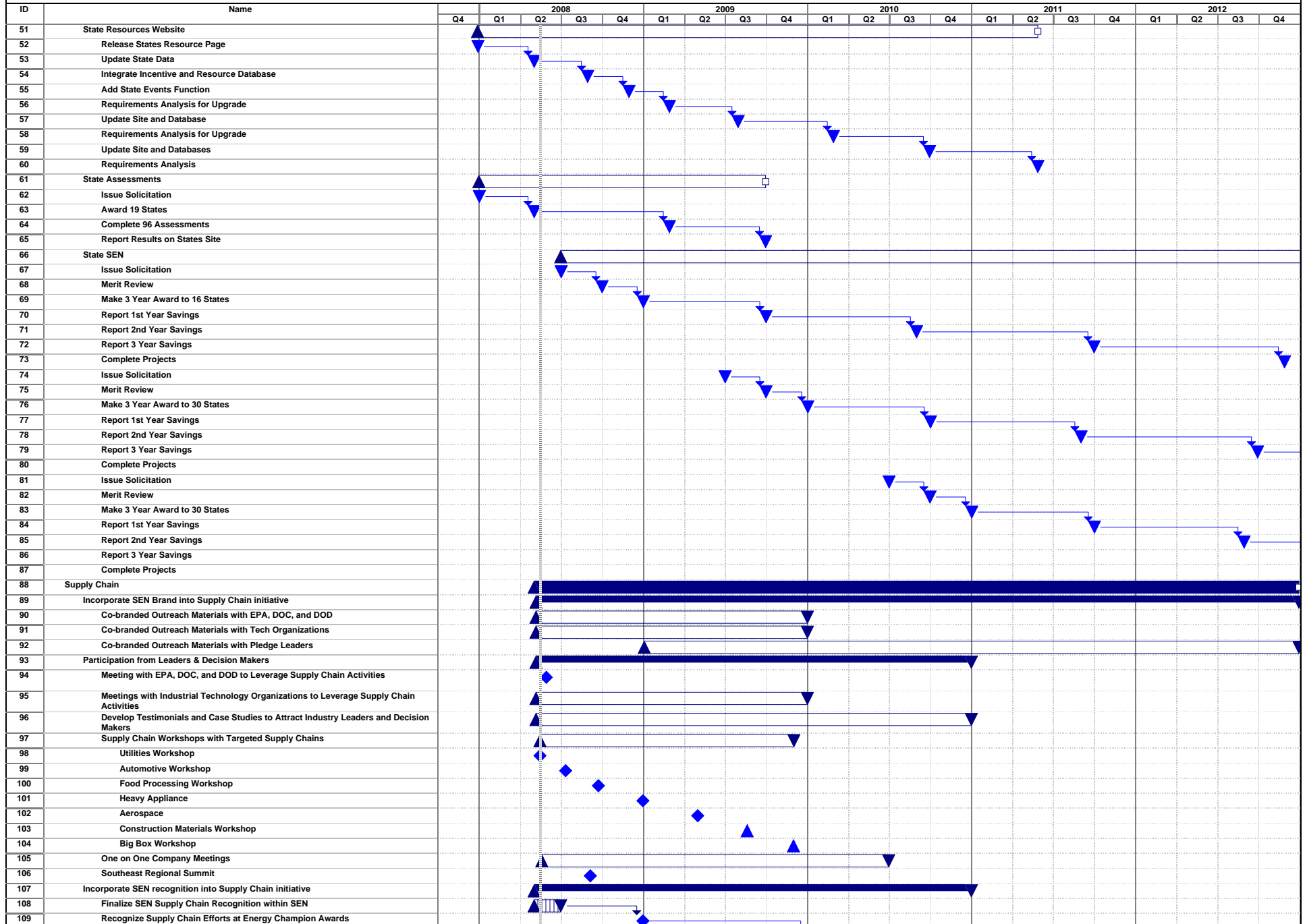
In addition to the activities above, there are several additional activities under development which create a pathway to achieving a 25 percent improvement in energy intensity over the next ten year period. These activities include the development of a comprehensive plant energy efficiency certification protocol. In addition, these activities will provide a long-term strategy for the industrial manufacturers to address and achieve cost-saving energy improvements leading to overall improved economic health.

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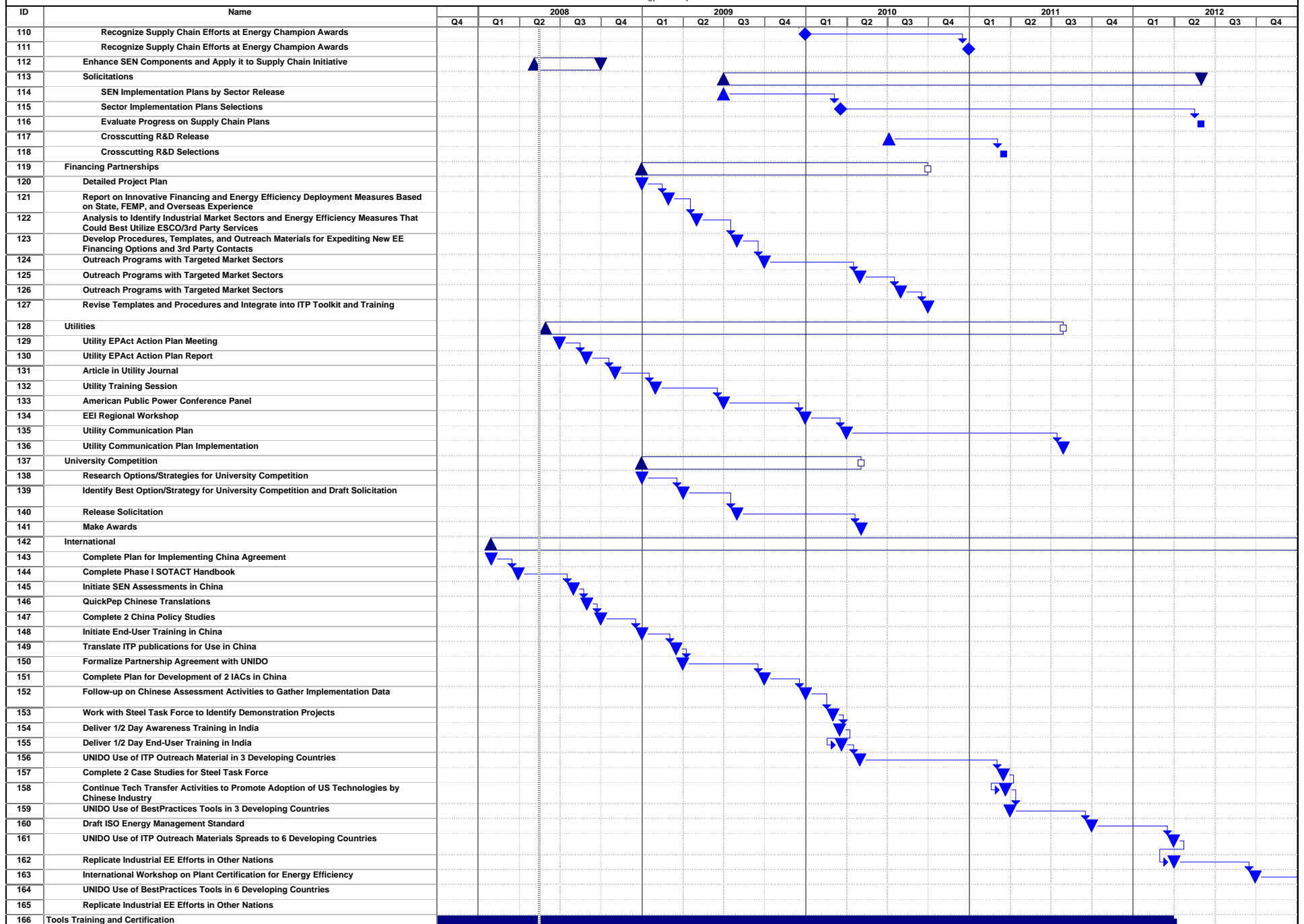
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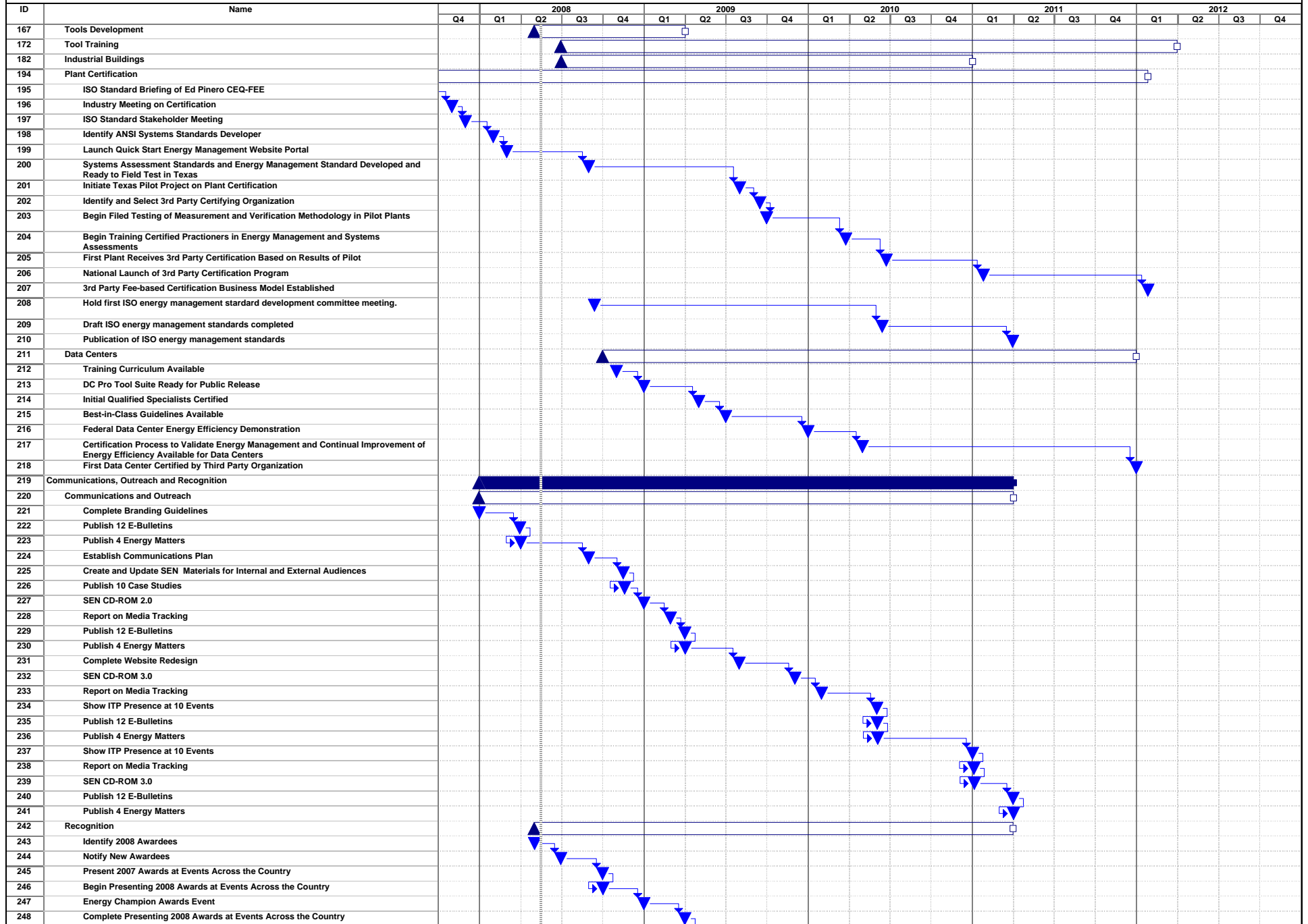
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Technology Delivery



Technology Delivery



Technology Delivery																							
ID	Name	Q4	2008				2009				2010				2011				2012				
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249	Identify 2009 Awardees																						
250	Notify New Awardees																						
251	Begin Presenting 2009 Awards at Events Across the Country																						
252	Save Energy Now Leader Awards																						
253	Energy Champion Awards																						
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259	Energy Champion Awards																						
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2.1.14.1 Assessments

Background

ITP's technology delivery approach offers a variety of energy assessments that enable industrial plants across the country to identify and implement energy-efficient upgrades and best energy management practices.

In 2005 the Save Energy Now (SEN) initiative was established as national initiative dedicated to helping industry reduce fossil energy use and carbon emissions while reinforcing energy efficiency as a profitable business model. The long-term goal of the new Save Energy Now Leaders initiative is to drive a 25% reduction in energy intensity in ten years. Through this initiative, Energy Savings Assessments (ESA's) are provided to encourage large industrial plants to reduce their energy intensity. These assessments focus on steam, process heating, compressed air, pump, and or fan systems within the plant.

ITP's Industrial Assessment Centers (IACs) program offers assessments and follow-up for small- and medium-sized U.S. manufacturers to identify opportunities for saving energy. An important benefit of the IAC program is the training of the next generation of energy-savvy engineers. The IACs are located at 26 ABET-accredited engineering schools across the country (Figure 3-a). Rutgers University serves as the Technical Field Manager, working in close collaboration with DOE and providing technical management for the IAC program. Under the supervision of professors, students perform 1-2 day assessments on a manufacturing facility's energy use, waste, and productivity.

Strategy

ESA's and IAC assessments continue to play an important role within the context of the Save Energy Now Leaders initiative:

- Both ESAs and IAC assessments in the future will give preference to Save Energy Now Leader companies.
- ESAs may be performed on multiple systems within a given plant based on the needs of the company
- Follow-up assessments by ESA Experts and IACs as well as technical assistance may also be provided to aid in assessment recommendation implementation
- IACs continue to train the next generation of energy savvy engineers, providing industry with the skilled workforce needed to face the energy challenges of the future.

Over time, partner organizations such as states, utilities, and engineering consultants will take a larger role in providing assessments:

- ITP will continue to provide a core level of ESA and IAC assessments
- States and other organizations will expand the reach of ITP by providing an increasing number of ESA and IAC style assessments to a broad range of industrial companies

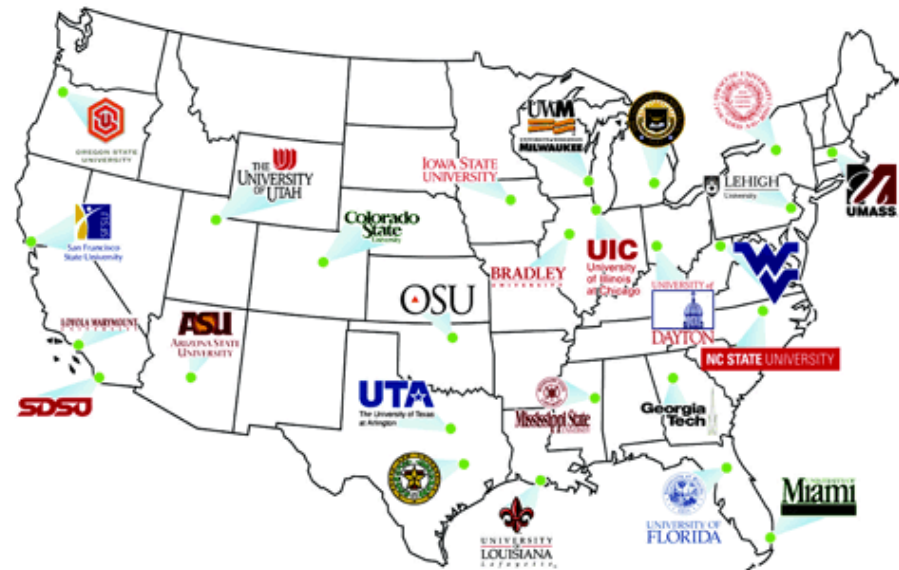


Figure 3-a. Location of ITP's Industrial Assessment Centers

- DOE focus will be to provide support to train Energy Experts and engineering students (IACs), ensure assessment quality, collect data and guide the overall assessment efforts.

Focus Area	Barriers	Pathways	Metrics
Energy Savings Assessments Teams of Qualified Specialists provide no-cost Energy Savings Assessments (ESA's) to large manufacturing plants each year.	<ul style="list-style-type: none"> Industrial facilities are not always aware of opportunities to improve plant processes that will result in energy savings and ultimately cost savings Plant personnel do not have the time or resources to spend on energy efficiency and energy efficiency improvements Energy use, while it can be a substantial cost of making product, is not often a priority when compared to issues such as safety, production and personnel issues. 	<ul style="list-style-type: none"> Provide tool based assessments (ESAs) that have a proven track record of success. Identify new opportunities for conducting assessments that will expand the type of assessment, the provider of the assessment and will more aggressively address project implementation and follow-up. Leverage partner organizations such as States and utilities that provide their own assessments. Work with these organizations to provided a continuum of resources that will achieve the highest level of savings and implementation opportunities for plants. Develop databases and other internal resources and reporting measures that capture all of the ITP and externally provided assessments so that results can be measured and reported in a consistent fashion. 	<ul style="list-style-type: none"> In partnership with States, utilities and others 500 industrial energy assessments / audits will be conducted annually to address the needs of companies and plants as it pertains to energy efficiency. Assessments will be collaborative and include project assistance and project implementation support. Assessments will be one of the key tools in helping industry define opportunities for improving their overall energy intensity by 25 percent over a 10 year period of time. Have a good implementation rate of recommendations made from ESA's. Increasing numbers of companies hire energy professionals and/or utilize their in-house expertise to adopt energy efficiency measures.
Industrial Assessment Centers (IAC) (1) ITP provides plant-wide energy, waste and productivity assessments to small and medium-sized companies each year with the goal of helping companies bridge the knowledge and resource gap and result in implemented energy-saving projects.	<ul style="list-style-type: none"> Small and medium sized companies with energy bills of less than \$3 million are unaware of low-cost, high- ROI, energy opportunities. (2) They also lack the know-how, staff and resources to effectively identify opportunities, propose solutions, and present to management. This results in a disproportionate burden on these already economically challenged businesses, in times of rising energy costs and/or disruptions in supply. (3,4) Engineering curriculum rarely includes components on energy management, 	<ul style="list-style-type: none"> Teams of engineering faculty and students from 26 university-based IACs provide no-cost energy, waste and productivity assessments to small and medium-sized companies each year. These assessments help these companies bridge the knowledge and resource gap and result in implemented energy-saving projects. Assessment results are catalogued in a user-friendly, publicly available website, further bridging the knowledge gap for a wider group of companies. Companies receiving assessments replicate assessment findings and 	<ul style="list-style-type: none"> The target industrial audience is very large and is continually in flux, with new companies needing to be informed of recent developments in industrial energy efficiency practices as well as older companies needing assistance determining ways to start or continue to improve their energy efficiency. In addition, the need for education and training of new energy efficiency engineers will not stop: new graduates from the IACs will be continually needed as the older graduates retire or move on to other jobs. However, in time the industrial

	<p>particularly in the non-power energy disciplines, such as mechanical systems. New engineers are not equipped to analyze energy impacts in engineering design and decision-making when entering the workforce. (1,5,6,7)</p> <ul style="list-style-type: none"> • New engineering graduates typically lack real world practical experience working in manufacturing and industrial plants. 	<p>implement additional energy saving projects at sister companies.</p> <ul style="list-style-type: none"> • A cadre of energy savvy engineers with real world experience is being trained for entry into the workforce to provide future impacts for entities of all types. • IACs will leverage the outreach of the NIST Manufacturing Extension Partnership (MEP) program in order to impact a larger number of small to medium sized companies. This will accomplished by mentoring and working collaboratively with MEP center staff to increase their awareness of ITP's energy efficiency tools and resources, thereby enabling the MEPs to transfer this knowledge to their extensive company client base. 	<p>culture will change, and companies will become more willing to provide support to the colleges educating their future energy management staff. As this happens, the requirement for federal funding will lessen.</p>
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2.1.14.2 Partnerships

Background

Despite progress in decreasing its energy and carbon intensity over the past 20 years, U.S. industry remains significantly underinvested in energy efficiency. ITP addresses the market, technological, and cultural barriers and finds ways to spur investments in the many remaining *cost-effective* opportunities to save energy and reduce carbon emissions. A key mechanism for accomplishing this is our Save Energy Now Leaders national initiative to drive a 25% reduction in industrial energy intensity in ten years. Through this initiative, ITP engages U.S. industry to implement cost-effective energy intensity and carbon reduction strategies. Save Energy Now is about partnerships. ITP alone cannot engage the thousands of industrial facilities across the country. In order to be successful, Save Energy Now must leverage access, resources and knowledge with other groups and industry to meet common goals.

Approach

The approach for Partnerships is to create a value-added chain that includes ITP and the Federal sector, State and local governments, not-for-profit energy efficiency organizations, utilities and the multitude of industrial trade associations who all share the common goals of energy and environmental improvements while sustaining the economic health of the industrial manufacturing sector. ITP engages the various partner organizations to determine what we can best bring to the table - within budget constraints - that allows these entities to deliver benefits to industrial end users. The outcome will be to transfer "ownership" of certain ITP activities to states, utilities, or others who are more appropriate for resource and tool delivery.

Focus Area	Barriers	Pathways	Metrics
<p>Voluntary Agreements</p> <p>Leaders of industrial companies are invited to take a bold pledge to reduce their corporate energy intensity and carbon emissions.</p>	<ul style="list-style-type: none"> • Industry must maintain market competitiveness while reducing energy intensity • Industry lacks resources (e.g., information on available technologies and practices, technical know-how, access to capital) to identify and implement energy efficiency improvements 	<ul style="list-style-type: none"> • Create a Save Energy Now Leader Pledge program where corporations, plants and supply chains agree to improve their energy intensity by 25% or more over 10 years and thereby demonstrating to the rest of industry that such an aggressive energy intensity reduction can be achieved cost-effectively. • Provide proven, cost-efficient energy management techniques and waive fees for ITP training workshops. • Provide tailored technical assistance and training on software tools. • Recognize program participation at national, state, and local levels. • Let companies use Save Energy Now logo to publicize their participation. • Create searchable database of current and past projects and success stories as a resource for pledging companies. • Encourage other stakeholders, i.e. utilities and local governments, to recognize corporate achievements. • Identify key partner organizations that can deliver the Save Energy Now tools resources and messages to the end-users (industrial plants and companies.) Identified organizations include, the Manufacturing Extension Partnerships (MEPs), National Association of Manufacturers, key trade associations and others who can take ownership in delivering ITP tools and resources to their customer/client bases. ITP will provide these organizations and entities the resources needed (or access to the 	<ul style="list-style-type: none"> • Increase the number of companies that sign the Save Energy Now Pledge (FY08 goal is 60) and disseminate energy efficient technical know-how across industry, leading to a 25 percent reduction in industrial energy intensity by 2017. • Pledge participants will report savings annually to achieve recognition status. • Emphasis on reducing energy and carbon intensity will become a part of industrial manufacturing culture.

		<p>resources needed) to engage individual companies and plants in energy efficiency practices and projects.</p> <ul style="list-style-type: none"> • Partner organizations will have a 25 in 10 pledge category and recognition for their successes. 	
<p>State Partnerships</p> <p>States and state organizations are essential partners for ITP to reach large numbers of industrial facilities.</p>	<ul style="list-style-type: none"> • No central repository of industrial efficiency resources (8) • Lack of awareness of local and regional resources (9) • Unique requirements in each state/region depending on the industry type, size, and primary energy source, negating one-size-fits all approach (10) • Need to reach more manufacturers with the tools and resources of ITP SEN (11) • Lack of internal resources to conduct assessments (12) • Unique requirements in each state/region depending on the industry type, size, and primary energy source, negating one-size-fits all approach (13) • Lack of internal resources (14) • Inability of staff to make business case to decision makers (15) • Need for technical assistance in implementation (16) • Need for objectivity and certainty on sustained technology performance (17) • Short funding cycle, disrupting continuity of effort (18). 	<ul style="list-style-type: none"> • Update current ITP State activities Web site to illustrate current ITP activities and industrial demographics. • Develop an incentive and resource database containing all rebates, incentives and resources available to manufacturers from state and local governments, non-profits, and utilities to help improve energy efficiency. • Incorporate announcement of events that are organized by the various state agencies into each state page. • Conduct requirements analysis to determine future enhancements. • Award and complete 19 State Save Energy Now plant assessments at local industrial facilities. • Report results of the 19 awarded assessments in states resource page. • DOE plans a solicitation to the states that will be a three year award for 16 to the states to begin the process of transferring Save Energy Now resources to the States. These awards will focus on providing resources to the states to conduct marketing and outreach, implement local training centers, conduct Save Energy Now assessments, conduct technology demonstrations, implement emerging and commercialize energy efficient technologies. A major component of this effort will also be to help 	<ul style="list-style-type: none"> • Provide a current and up to date central repository of all of the tools and resources available to a manufacturer, organized by state along with a list of activities ITP has performed in each state • Leverage a small amount of funds to reach more manufacturers with the tools and services of SEN to increase the number of plants to receive assessments • Provide the states with the tools and resources to assume an ownership role of the Save Energy Now activities, and customize resources to meet the local needs of manufacturers. • States will report energy savings annually and will be recognized for success. • States will be partners in the Save Energy Now campaign and will have ownership of helping local manufacturers stay competitive through efficiency. • ITP will be out of the delivery business and focused on adding value to local state efforts by addressing their priority needs.

		<p>manufacturers implement projects through technical assistance, access to capital, and identification of appropriate rebates and incentives available to help mitigate the cost of the projects.</p> <ul style="list-style-type: none"> • In year 2 DOE will issue another solicitation to the states that will be a three year award for an additional 16 to the states to begin the process of transferring Save Energy Now resources to the States. • In year 3 DOE will issue another solicitation to the states that will be a three year award for an additional 16 to the states to begin the process of transferring Save Energy Now resources to the States. 	
<p>Supply Chain</p> <p>The Supply Chain Initiative drives energy savings throughout their supply chains using ITP's Save Energy Now, and with targeted high-impact industries to develop roadmaps to identify research needs to decrease the embedded energy intensity of final products.</p>	<ul style="list-style-type: none"> • Gain recognition of SEN's applicability across industrial supply chains • Attract new/more companies to SEN through the supply chain initiative • Formulating a recognition plan that is attractive for pledge members to encourage their suppliers to join • Organizing suppliers to address energy savings as a supply chain • Addressing R&D needs of suppliers who supply multiple supply chains 	<ul style="list-style-type: none"> • Enlist supply chains into voluntary Save Energy Now Leader pledge program to demonstrate energy efficiency results • Co-brand testimonials, presentations, and outreach materials with EPA, DOC, industrial technical organizations, and pledge members to demonstrate energy savings opportunities through supply chains. • In FY08-FY09, work with EPA and DOC voluntary programs and partnerships to leverage resources and attract industry leaders and decisions-makers. • In FY08-FY09, facilitate supply chain workshops with supply chains to develop plans on how to implement SEN down their supply chains. • Conduct company one-on-one meetings to develop plans on how to implement SEN down their supply chains. 	<ul style="list-style-type: none"> • Target new and more industries for energy savings by implementing SEN across supply chains.

		<ul style="list-style-type: none"> • In FY08, enhance SEN recognition to include supply chain activities. • In FY09, conduct solicitation for supply chains to develop SEN implementation plans. • In FY10, conduct R&D solicitation to address R&D needs for suppliers who crosscut multiple supply chains. 	
<p>Deployment Support and Financing</p> <p>This ITP deployment and financing strategy is to integrate ITP R&D and TEAM activities with current and new Technology Delivery Venues and Partnerships while highly leveraging existing resources within ITP (i.e., IACs, RACs, etc.) and other EERE program offices (excluding FEMP).</p>	<ul style="list-style-type: none"> • Potential changes in production or the process during the term of a contract with 3rd party financier add risk to guaranteed savings approaches • Accounting requirements for shared savings approaches can be daunting due to Sarbanes-Oxley, which has introduced much more complexity in the contract process. It is no longer easy to shift risk • General feeling that an ESCO or third party may not understand the plant process well enough to effectively implement a project • There could be concern about confidentiality of intellectual property any time a third party is involved in a process modification • Energy efficiency investment must, like all potential investments, meet strict payback hurdles. All industrials are tight on capital and must prioritize investment opportunities. 	<ul style="list-style-type: none"> • Identify key barriers to energy efficiency investments in the industrial sector. • Review existing financing options for industrial energy efficiency projects and identify shortcomings. • Identify innovative state and overseas approaches to financing that could be effectively incorporated into a national program. • Work with ESCOs and the financing community to develop innovative financing and implementation programs for industrial energy efficiency deployment. • Identify value-added services that ESCOs and other third party providers can bring to energy efficiency investments. • Identify specific industrial market segments that can best benefit from these services. • Develop joint solutions that build on the value added services of third party providers and the specific needs of industry. • Roll-out the recommended solutions at annual meetings, trade shows, ITP website, through webinars, etc. • Highlight success stories and comment procedures/approaches. 	<ul style="list-style-type: none"> • Resources will be readily accessible to assist manufacturing facilities with the means to address the financial and technical constraints associated with energy and environmental project implementation. • Partners such as utilities and states will provide information and access to these resources. • Partnerships between industry, ESCOs and other 3rd party financiers to implement energy efficiency projects and investments are a well-established practice in the United States.

		<ul style="list-style-type: none"> • Fold these results into the SEN toolkit and training program. 	
Utilities Utilities are the front-line partners for engaging industrial facilities in energy and environmental projects.	<ul style="list-style-type: none"> • Need to incorporate utilities into the deployment strategy (18) • Due to natural market conditions industry remains significantly underinvested in energy efficiency • Federal government is not well suited to deliver resources directly to the end-users • Industrial customers are resource and time constrained, opportunities to engage in new projects or implement new ways of doing business provide particular challenges for industry, no matter how beneficial these may be. 	<ul style="list-style-type: none"> • Engage the utility community and develop partnerships to provide utilities with the tools and resources to help improve the energy efficiency of the industrial customers they serve. This includes providing outreach material through national utility associations, developing of a utility action plan, and conducting training with utility personnel so they have the resources available to help their industrial customers. 	<ul style="list-style-type: none"> • Utilities nationwide will adopt aggressive industrial energy efficiency demand side management programs and be largely responsible for the ability of facilities to achieve “25 –in-10” goals. • Utilize the gas and electric utilities as a channel to reach manufactures to help improve their energy efficiency. By providing the utilities with these resources, ITP will reach more manufacturers because the utility personnel have an established relationship with the manufacturers and are the first people who are called when their energy bills are high • Adoption of many aspects of the delivery of ITP plant resources will belong to the private sector, including utilities, trade associations and other key partner groups. Substantially larger numbers of industrial facilities will be reached due to the leverage of these partner organizations. The unique relationships of the industrial facilities to these partner organizations will insure greater adoption of projects and improvements.
University Competition This competition will focus on bringing cutting-edge energy and	<ul style="list-style-type: none"> • New engineers are not equipped to analyze energy impacts in engineering design and decision-making when entering the workforce or to address 	<ul style="list-style-type: none"> • University competition (DOE solicitation) to develop novel approaches to in-plant industrial challenges. 	<ul style="list-style-type: none"> • Enhanced connection and partnership between universities and innovative ideas in lock step with industry needs. Universities

environmental technologies from universities to the plant floor, which is typically not a cost-effective option for most facilities.	<p>current issues in industrial energy efficiency.</p> <ul style="list-style-type: none"> • Disconnect between engineering curriculum and industry needs. 		<p>prepare graduates that can “hit the ground running” in industry and develop and implement novel approaches to address industrial energy efficiency needs.</p> <ul style="list-style-type: none"> • Top universities participate in the competition. • Industrial associations partner to issue the competition and sustain it over time.
<p>International</p> <p>ITP works with interested international partners to deliver energy and environmental resources to support industrial energy efficiency needs in these countries.</p>	<ul style="list-style-type: none"> • Intergovernmental complexities • Energy reduction targets vary among partner countries • Different policy perspectives • Language/cultural differences • Varying natural resources and infrastructures • Varying budget priorities/cycles/exchange rates • Time Zone difference 	<ul style="list-style-type: none"> • MOUs with partnering countries [ex. China] or partnering organizations [ex. UNIDO]. • Translate and distribute U.S. software tools, training, and publications. • Support the development of IACs in partnering countries. • Provide pilot energy savings assessments in partnering countries. • Provide pilot training and awareness classes in partnering countries. • Continue APP task force activities. • Continue SOTACT activities with cost-shared State funding. • Participate in the development of an international ISO energy management standard. • Participate in an international workshop on plant certification. • Demonstrations of emerging and commercial U.S. produced technologies. • Technical transfer activities to promote adoption of U.S. technologies by other member countries. 	<ul style="list-style-type: none"> • Partnerships between emerging and developed countries. Shared best-practices among partner countries. Self-replicated, self-funded future industrial energy efficiency activities. Increased commercialization and sales of U.S.-produced energy-efficiency technologies, knowledge and services. • Establishment of partnerships between emerging and developed countries to share best practices information. • Increase in self-replicated and funded industrial energy efficiency activities. • Increase in the commercialization and sales of U.S.-produced energy efficiency activities.

2.1.14.3 Tools, Training and Certification

Background

Technology Delivery is developing a variety of new products, services, tools and energy-efficiency resources to assist industry in accelerating their energy intensity reductions. ITP is asking industrial plants, corporations and supply chains in FY2008 to pledge to reduce their energy intensity by 25% or more over a ten-year period. Therefore, all new ITP energy efficiency products being developed or upgraded are being directed towards helping companies meet the "25-in-10" pledge. For example, ITP's software tools are being improved and upgraded to ensure that they are easy to apply and can effectively assist plant personnel in performing energy assessments, and validating and documenting energy saving results.

Building off the portfolio of ITP tools and success in performing Save Energy Now energy assessments, ITP is embarking with industry to standardize the process of implementing an energy management program. DOE is partnering with NIST, EPA, the American National Standards Institute (ANSI) and leading industrial companies to create voluntary, industry ANSI-accredited standards to allow manufacturing facilities to certify their continual improvement of energy intensity.

Finally, ITP is expanding its portfolio of tools and training to address significant energy savings associated with industrial building facilities and rapidly growing sectors of the economy such as data centers.

Approach

ITP tools and energy efficiency resources have demonstrated value to industry in stimulating investment in energy efficiency that would have not occurred otherwise. To date, we have impacted over 16,000 manufacturing facilities. In accord with the "25-in-10" goal, ITP needs to influence the majority of the 200,000 manufacturing facilities in the United States by accelerating their energy intensity reduction rate to 2.5% per year (more than double the current rate of improvement). We are working with industry to codify and create voluntary industry standards that "institutionalize" Save Energy Now best practices and protocols so that manufacturing plants can certify their energy efficiency program. A key mechanism for companies to meet the pledge will be certification of plants for energy efficiency.

Focus Area	Barriers	Pathways	Metrics
Plant Certification The ANSI-accredited plant energy-efficiency certification process is a voluntary third-party certification program being developed by industry and governmental organizations to promote improvements in current industrial energy management practices and elevate energy management within corporate priorities.	<ul style="list-style-type: none"> Currently, there is no platform for a consistent approach to industrial energy efficiency and energy management There is no mechanism to promote sustainable energy savings within industry There are no common standards of how to assess specific industrial energy systems, such as steam, process heating, compressed air and pumping There is no way for industry to receive third party validation of their energy efficiency gains and carbon emission reductions at the plant facility level. 	<ul style="list-style-type: none"> Develop and test system assessment standards Revise ANSI energy management standard and test its applicability in pilot plants with the energy management tool Develop and test facility-level measurement and verification standard and the overall third-party certification process with pilot plants Launch American National Standards Institute-accredited certification process at facility-level with third-party validation throughout the U.S. 	<ul style="list-style-type: none"> Facilities have the mechanism to have their industrial energy management and energy intensity validated by a respected and internationally-recognized third-party certification system. Third-party certifying organization is financially self-sufficient and not dependent on DOE funding. Supply chains require that their suppliers get certified as proof that an energy management program is being implemented and energy savings are being achieved. First plant certified in 2010. 1,500 plants certified by end of 2013. 5,000 plants certified by end of 2016.
Training The training program focuses on delivering the tool suite and insures that plant personnel and end users can effectively apply the resources developed by DOE.	<ul style="list-style-type: none"> Effective implementation of energy efficiency practices and projects requires training Tool training opportunities are limited, but when accomplished training has a substantial impact for the investment There is a need to develop a cadre of trained specialists who can use DOE and other industry tools as part of their business portfolio to deliver industrial energy efficiency. 	<ul style="list-style-type: none"> Develop web-based training as a means to reach more users. In conjunction with partnership activities, work with external entities to grow training hosts outside of the ITP fully funded model; States, and utilities would be target hosts Develop overall plant energy management training module in conjunction with EPAct section 106. Provide continuous updates and modifications to existing training curriculum to insure the most accurate and up-to-date material is included to remain consistent with new and 	<ul style="list-style-type: none"> Approximately one-third of all plants that participate in a DOE end-user training program implement actions in their facilities as a result of participating in training and approximately one-half of participants who participate in Qualified Specialist training result in actions taken in facilities. In FY2008 this will account for almost 3.9 trillion Btu in industrial energy savings. Adoption of all aspects of the training delivery activity by the private sector, under the guidance but with minimal financial support, from the Federal Government. Provide multiple training venue options including distance learning

		updated tools.	<p>and electronic formats to achieve maximum reach.</p> <ul style="list-style-type: none"> • Transition the hosting of training sessions to states and utilities to best service their customers and clients needs. • Training is integrated with the ANSI-accredited standard adoption required in the energy efficiency certification process for manufacturing plants.
<p>Industrial Buildings</p> <p>The IAC program experience has shown that implementation of industrial buildings recommendations yield simple paybacks of 1-2 years.</p>	<ul style="list-style-type: none"> • Unique requirements and opportunities depending on the industry type, size, available energy, lighting demands - negating a one-size-fits all approach • Lack of internal resources. • Inability of plant staff to make compelling business case to decision makers • Need for technical assistance in implementation • Need for objectivity and certainty on sustained technology performance • Savings opportunities are assumed small and unavailable. 	<ul style="list-style-type: none"> • Develop communications regarding resources – current tax benefits via BTP software • Develop integrated industrial buildings QuickPEP scoring module and industrial buildings software tool. • Validate QuickPEP Module and Industrial Buildings tool. • Develop training for tool. • Develop plans to facilitate Industrial Buildings BestPractices and technologies through federal and state and utility-based Save Energy Now delivery. • Demonstrate technologies • Implement emerging and commercialized energy and water efficient industrial buildings and facilities technologies, in partnership with states and utilities/ESCOs. • Provide options for clean energy / CHP . • Provide options for renewable energy. • Develop documents / webcasts 	<ul style="list-style-type: none"> • Agreements with utilities and ESCOs to deliver industrial building BestPractices and technologies. • Industrial building technologies and best practices are commonly implemented whether domestically or internationally. • Leverage partnerships with industry, state, utility/ESCO partners to deliver these Industrial Buildings BestPractices. • Provide Industry, State/Regional Experts with the tools and resources to conduct Save Energy Now activities including industrial buildings. • Convey tool, training, webcasts and fact sheets into integrated industrial energy systems software tool, training and catalog systems for low-cost electronic delivery. • Minimally customize these resources for manufacturing sub-sectors where the average industrial buildings consumption in the sub-sector is > 10% of the total consumption in the

		<p>including streaming video archives for industrial buildings.</p> <ul style="list-style-type: none"> • Leverage / update CHP and buildings resources as required 	<p>sub-sector.</p> <ul style="list-style-type: none"> • Save 0.25 Quad / year - source energy in industrial buildings.
<p>Data Centers</p> <p>ITP is building a portfolio of energy efficiency resources to assist data center operators to capture energy savings.</p>	<ul style="list-style-type: none"> • Lack of definitions for equipment and data center energy efficiency • Differing priorities between IT and facility managers • Adoption of energy efficiency practices and technologies viewed as a risk 	<ul style="list-style-type: none"> • Develop "DC Pro" tool suite with consensus metrics that will facilitate IT and facility people to more effectively communicate and establish complementary priorities • Develop "Best in Class" guidelines • Develop Qualified Specialist certification program • Create Save Energy Now case studies of energy efficiency success stories through performing pilot energy assessments 	<ul style="list-style-type: none"> • Save 10 billion kWh per year by 2011. • 200 people certified as Data Center qualified specialists by 2011. • 1,500 data centers have reduced their energy intensity by 25% from 2008 to 2011. • Distributed generation systems are commonly implemented at data centers. • DCIE performance rating factor (IT to Total data center energy use) of 0.70 or more achieve by >50% of large enterprise class data centers.
<p>Tools and Guidelines</p> <p>ITP seeks to increase the involvement of partners in developing and disseminating tools, thereby improving industry awareness of energy savings opportunities and ITP tools as well as raising the priority of energy savings projects at plants.</p>	<ul style="list-style-type: none"> • Plants are often unaware of low-cost, high-ROI, energy savings opportunities¹ • Plants often lack the expertise or training needed to identify and implement energy efficiency projects. This expertise includes the ability to identify opportunities, propose solutions, and present these results to management for funding (1) • Plant engineers and operators have expertise in the use of more than 2 ITP Tools along with limited time (19) • Plants are often unaware of the available ITP tools (1,19,20) • Current tool users are often only single tool users that are unaware of the other ITP tools that could help them save energy in other parts of 	<ul style="list-style-type: none"> • Increase the involvement of partners in developing and disseminating tools. Increased involvement will improve industry awareness of energy savings opportunities and ITP tools as well as raise the priority of energy savings projects at plants • Expand existing tool capabilities via ITP's Web site • Expand individual stand alone existing tool capabilities • Utilize tool suite to assist plants in adopting ANSI-accredited energy management system assessment standards 	<ul style="list-style-type: none"> • By 2012 18% of the large energy using plants will realize energy savings utilizing DOE Software Tools. • DOE Software tools will take on an increase role in assisting plants in their energy management and ANSI Certification efforts. • Well developed software tools will allow industrial plant personnel to engage in energy efficient projects and the use of ITP tools to facilitate project implementation. • Actions taken that result in energy savings from individuals who have acquired ITP software tools is measured.

	<p>their plant (20,21)</p> <ul style="list-style-type: none"> • Current tools were developed by different partnerships and organizations, resulting in different designs and capabilities. These differences require users to devote time to learn how to use each. 		
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2.1.14.4 Technical Information and Outreach

Background

Through communications, ITP broadens awareness about industrial energy efficiency benefits and opportunities and provides access to technical information, tools and methods. Outreach activities establish ITP as a key industrial resource in energy efficiency and facilitate collaborations across industries. Through outreach, ITP can extend its reach to more facilities and other organizations that can promote the Program's resources. We have a comprehensive portfolio of technical information and tools to help plants learn about and deploy energy efficiency measures. By building awareness, providing access to resources, and maintaining outreach, ITP creates a call to action for industry, facilitates adoption of technologies and methods, and ultimately helps transform behavior with regard to industrial energy use and energy management practices.

Approach

ITP is developing multiple delivery items for industrial audiences ranging from end users to states energy offices, utilities, and others interested in industrial energy efficiency. We continue to expand our audiences and adapt our communications products to meet evolving priorities. ITP also recognizes companies who pledge to reduce their energy intensity 25% over ten years.

Focus Area	Barriers	Pathways	Metrics
Technical Information ITP develops a portfolio of technical publications to help industrial end users understand and apply energy efficiency practices.	<ul style="list-style-type: none"> • The size and diversity of the industrial audience creates a need for ongoing communication to broadly deliver ITP resources and strategies. • ITP partners such as associations and utilities need access to ITP branded resources to boost or complement their own activities. • Industrial plants may not be aware of cost, productivity, and environmental benefits and opportunities of implementing energy efficiency • Industrial plants need access to reliable, proven resources, methods, and technology information that enable them to take action on improving energy efficiency 	<ul style="list-style-type: none"> • Develop and maintain a robust portfolio of industrial energy efficiency resources to increase awareness of opportunities, technical knowledge, and increase commercialization of technologies. ITP creates and makes available these resources for printed or electronic distribution: • Technical tip sheets, sourcebooks, guides, and briefs • Assessment and corporate management case studies • ITP assessment and analysis software tool suite • Energy Matters online quarterly with a focus on technical and practical information • Technology fact sheets • The Save Energy Now CD: portable collection of tools and information resources • Topical Webcasts: focus on system specific tools or training • Produce the monthly ITP E-Bulletin for program current news • Establish and adhere to program identity, including consistent use of Save Energy Now brand and logo, creating branding and co-branding guidelines and opportunities. 	<ul style="list-style-type: none"> • ITP will collect metrics and feed-back on the use of its resources by industrial customers. For <i>Energy Matters</i> and <i>E-Bulletin</i>, ITP measures increases in recipients, Web statistics, and feedback. We will track <i>Energy Matters</i> article reprints by other media to measure reach to other audiences. The success of the <i>E-Bulletin</i> will also be measured by increased activity in other program areas or website.
Website Management	<ul style="list-style-type: none"> • Accessibility and searchability are limited, making it hard for companies 	<ul style="list-style-type: none"> • ITP, BestPractices, and Save Energy Now Web sites: provide a constant 	<ul style="list-style-type: none"> • ITP's websites provide a valuable measure of progress toward

ITP's websites provide the main point of access to resources, tools, and activities.	to find the information needed	and up-to-date home for resources and program information <ul style="list-style-type: none"> • Increase reach and accessibility so website helps change behavior through repeat visits and by attracting new visitors. • Maintain news and events on the Web sites 	increasing awareness and action. Recognized statistical techniques (on audience size, paths from other sites, downloads, etc) will be used to measure success. ITP evaluates accessibility from search engines, such as Google, and continually adapts content to optimize searches.
Outreach and Media Outreach expands and strengthens program identity and increases awareness of activities, results, and opportunities - necessary steps toward assimilation of energy management practices.	<ul style="list-style-type: none"> • Need to multiply ITP's reach, and industrial audiences will progressively gain interest and motivation to improve energy efficiency and participate with the program. 	<ul style="list-style-type: none"> • Expand and strengthen program identity and increases awareness of activities, results and opportunities through outreach activities • Target and attend energy events across the country • Develop and promote activities through corporate reports, brochures, and results summaries • Create targeted campaigns and mailings 	<ul style="list-style-type: none"> • Responsiveness to other program areas is a reflection of successful outreach implementation. Actions range from tool download/use to training to implementing new technologies. Outreach will also contribute to the quality and level of participation by partnering organizations. Media coverage tracking/reporting measures reach and success of name recognition.
Information Center The EERE Information Center provides an on-call staff of specialists to assist end users and service providers.	<ul style="list-style-type: none"> • Need to transform behavior of industry decision-makers by improving their awareness of energy-saving opportunities 	<ul style="list-style-type: none"> • Enable decision-makers to obtain the necessary technical, financial, and management support to successfully implement them and then to replicate their success at other plants within their company 	<ul style="list-style-type: none"> • One indicator of success is the # of clients who take action. Success would also result in clients returning with additional inquiries as they build their knowledge and support to expand their activities to save more energy and have their coworkers contact the Information Center with inquiries of their own.
Recognition ITP recognizes and rewards plants and companies who have achieved significant energy savings.	<ul style="list-style-type: none"> • There are no programs in place to recognize and reward plants and companies that have made significant progress in saving energy and implementing energy saving best practices and technologies • Department of Energy does not have any other award programs to 	<ul style="list-style-type: none"> • Recognize and reward plants and companies who have achieved significant energy savings • DOE ITP Recognition Program recognizes 2 levels of plant energy savings as well as replication of energy savings within companies. 	<ul style="list-style-type: none"> • The culture of the U.S. industrial base will respond to the recognition activities being conducted by ITP by investing in energy efficiency. The industrial sector will understand the value of energy efficiency in terms of cost savings, environmental benefits,

	<p>recognize significant efforts related to energy use</p> <ul style="list-style-type: none"> • Companies often require positive marketing incentives in order to see the benefits of investing in energy efficiency. 		and improved competitiveness.
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2.2 Cross-cutting Issues

2.2.1 Communication and Outreach

Communications and Outreach Strategy

The Industrial Technologies Program is the lead government agency responsible for improving energy efficiency and reducing carbon emissions in industry. Our goal is to drive a 25% reduction in U.S. industrial energy intensity by 2017 in support of the Energy Policy Act of 2005 (EPAAct 2005). At the highest level, we will achieve this by:

- Promoting a corporate culture of energy efficiency and carbon management
- Developing real-world energy solutions for industry
- Expanding the use of proven technologies and practices

Implementing this strategy will require clear communication to a variety of external and internal audiences. Unlike other EERE programs, ITP must convey the value of efficiency improvements in many different applications throughout industry. Public-private partnerships are essential in delivering our communication products and services to such a large and diverse economic sector. We use our relationships with organizations that possess strong ties to large subsets of industry to create a multi-channel delivery approach that leverages limited ITP resources to greatly expand outreach and effectiveness.

In 2008, ITP is launching a major campaign to promote the EPAAct 2005 goal of reducing industrial energy intensity by an average of 2.5% over 10 years, which will require elevating energy efficiency as a corporate priority within industry. Accomplishing this will require a comprehensive communications and outreach strategy that clearly defines key messages, products, channels, partners, and events. Every ITP staff member is in effect a “program ambassador” as well as customer service representative, and must be able to deliver a consistent message to both existing and potential partners.

ITP’s communications and outreach strategy will focus on five key elements to achieve Program goals:

- **Communications Products** – Create/update targeted publications to promote awareness of ITP products and services (including current R&D projects) and to make the business case for energy efficiency and carbon reduction (including fact sheets, success stories, case studies, brochures, presentations, journal articles, press releases, annual reports, and commercial products catalog); maintain up-to-date website and continually improve its ease of use; develop innovative web-based products
- **Stakeholder Development** - Develop and carry out activities to expand ITP’s stakeholder base, encourage companies to elevate energy efficiency as a corporate priority, facilitate dialog between industry and ITP on working together to achieve mutual goals, and engage stakeholders as partners in disseminating ITP products and promoting energy efficiency
- **State, Regional, and International Partnerships** – Establish partnerships with states to cooperatively seek energy intensity reductions; hold strategic events with states to conduct training and energy assessments and publicize state energy intensity reduction achievements; strengthen partnerships with International Energy Agency, China, and other countries to maintain a U.S. leadership role in international energy efficiency
- **Voluntary Agreements, Certification, and Recognition Programs** – Create and implement Save Energy Now/“25 in 10” initiative to reduce industrial energy intensity by 25% over 20 years; conduct a major marketing campaign to promote the initiative and encourage corporate pledging; develop an ANSI standard to certify industrial facilities for energy management and energy intensity improvement; recognize industrial companies’ accomplishments in reducing energy intensity
- **Events** – Conduct technology showcases and demonstration events; participate in other media events to launch new technologies or publicize industrial accomplishments; conduct pledge signing events for the Save Energy Now/“25 in 10” initiative; participate in MOU signing events

ITP's Communications and Outreach Strategy	
Element	2008 Milestones
Communications Products	<ul style="list-style-type: none"> • Release Save Energy Now CD (version 3) • Update and publish <i>Energy Technology Solutions</i> product catalog • Prepare and post updated fact sheet for every active R&D project • Publish new ITP strategic plan
Stakeholder Development	<ul style="list-style-type: none"> • Expand activities with National Association of Manufacturers (NAM) • Sign MOU with USCAR • Develop partnerships with copper, titanium, and cement industries • Develop industry steering committee to advise ITP management
State, Regional, and International Partnerships	<ul style="list-style-type: none"> • Develop and sign MOUs with three (3) additional states • Develop a resource assessment plan with NASEO • Select ~20 states to receive funding to conduct Save Energy Now assessments
Voluntary Agreements, Recognition, and Certification Programs	<ul style="list-style-type: none"> • Launch Save Energy Now/"25 in 10" initiative with at least 60 companies signing voluntary agreement to reduce energy intensity by annual average of 2.5% per year over 10 years • Present Energy Champion awards at NAM National Manufacturing Week • Complete key steps in the development of a plant energy management certification process, including revisions to ANSI standards and development of system assessment protocols and measurement/verification methodology
Events	<ul style="list-style-type: none"> • Conduct Super Boiler demonstration at Clement Pappas & Co. in Ontario, CA • Support and participate in Southeast Energy Summit • Conduct CEO Save Energy Now/"25 in 10" pledge-signing ceremony • Host event at large industrial facility to celebrate completion of 500th Save Energy Now assessment

Figure 2-c: ITP's Communications Strategy

Collection of Market Information for Decision-Making

ITP collects market information from a variety of sources for use in technology development decision-making. This information often becomes integral to ITP's analytical studies and reports. More discussion on this topic can be found in Section 3.

Dissemination Channels to ITP Stakeholders and Contribution to Program Success

ITP relies heavily on partnerships and leveraging opportunities with organizations such as trade and technical associations, state energy offices, utility companies, and other federal agencies to disseminate vital information and services. In FY08, ITP's collaboration with NIST's Manufacturing Extension Partnerships on plant audits is being expanded to help more plants identify opportunities for improving energy performance. In addition, ITP will increase efforts use a wider variety of venues and channels (e.g., technical and

financial print media, novel web-based methods, and regional and national events) to communicate to stakeholders. A more robust network of dissemination partners and mechanisms will accelerate the spread of information and deployment of new energy-efficient technologies that can help industry achieve greater near-term benefits.

Program Use of Stakeholder Feedback

ITP uses feedback from stakeholders throughout the technology development lifecycle, from strategic planning through technology commercialization, and highly values this input. The feedback is often received via peer review activities, which is discussed further in Section 3.3.1.

Interaction with EERE's Corporate Technology Advancement and Outreach Office

ITP coordinates communications and outreach activities with EERE's Technology Advancement and Outreach Office. EERE's Technology Advancement and Outreach liaison to ITP ensures that ITP follows the guidance set forth regarding communications and outreach activities.

2.2.2 Other Cross-cutting Issues

Commercialization and Deployment

Commercialization and deployment of new technologies is a critical issue that ITP is emphasizing throughout the R&D cycle – from planning, solicitation, and project selection through the various stages of R&D. ITP recently completed 25 Commercialization Readiness Assessment Briefs for its technologies, which included a set of observations and recommendations that the Program will incorporate into its management procedures. These recommendations include:

- Proposals funded by ITP should
 - Identify a commercialization champion to position technology for market adoption
 - Express the awardee organization's commitment to commercialization
 - Include a competitive analysis identifying both present solutions and other emerging technologies addressing the same need
- Funding Opportunity Announcements (FOAs) will
 - Require the applicant to demonstrate understanding of a technology's market and commercialization aspects
 - Request details relating to the planned commercialization of the technology
- A targeted completion date and milestones will be required for the commercialization process
- Awardees will be explicitly reminded of their obligations under a federal contract to disclose any new inventions arising from funded research
- GFO Project Managers will increase communications with ITP's Technology Managers regarding progress on both the technical and commercialization fronts
- Program managers will continue to emphasize leadership on commercialization and deployment

Furthermore, ITP will participate on the soon to be developed FEMP TEAM Coordinating Council within EERE to support FEMP's implementation of Executive Order 13423 to reduce DOE energy intensity. In order to assist in the deployment of ITP technologies and knowledge throughout DOE, ITP intends to provide a webinar on ITP opportunities for interested energy complex Facility Managers and ESCOs, and also provide technical assistance where appropriate.